

Date Wednesday, 15/08/2007 9:46:22 AM
User Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY LH
Job Number : 33901
Estimate Number : 10800
P.C. Number : *N/A*
This Issue : 15/08/2007 S.O. No. : *N/A*
Prsht Rev. : NC Part Number : D350600141
First Issue : *N/A* Type : SMALL /MED FAB Drawing Number : IIN REV.C PG11,18-21
Previous Run : 33436 Project Number : N/A
Written By : Due Date : 22/08/2007 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est Rev:D 05.04.14 Incorporated procedures from D3187-1/-2 K
J/JLM
Est Rev:E 06-11-20 As per DSI9335 JLM
est rev F 07.02.07 iin rev.c ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG003

2.0 33901A SWITCH RELOCATION KIT



349



Comment: Sub-Component SWITCH RELOCATION KIT

B33789

3.0 33901B w/o 30080 SPACEPOD BODY LH



Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: B 30080

ml 07/08/15

4.0 33901C SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-1 B 33901C

ml 07/08/15

5.0 D31871 Spacepod Floor



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3187-1

Floor

D31835 → in store already painted

1 D3186-1

Door (ref)

B33901C

1 D3188-1

Body(ref)

B 30080

ml 07/08/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 9:46:22 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001-Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 33901

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

ALS41032130

Insert



Comment: Qty.: 28.0000 Each(s)/Unit Total: 28.0000 Each(s)

Pick:

Qty Part Number Description Batch

28 ALS4-1032-130 Insert *2103495*

JP

07/08/15

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Transfer drill (#30) from D3187-1 into D3188-1.

N/A use size DT89.70 for 1/4"

2-Open holes in D3188-1 body floor to Ø0.297".

3-Install inserts in D3188-1 as per Dwg D3188.

4-Open holes in D3187 ~~X~~ aluminum floor to 0.250" per dwg D3187

N/A

5-Deburr holes in ~~X~~ D3187-1

N/A

ml 07/08/16

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/08/16

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

*****D3187-1 floor only*****

Chemical Conversion Coat as per QSI 005 4.1

N/A

N/A

ml 07/08/15

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*****D3187-1 floor only*****

- Powder-Coat Black Sandtex (Ref: 4:3.5:7) as per QSI 005 4.3

N/A

ml 07/08/15

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

n/a
ml 07/08/15

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

n/a
ml 07/08/15

13.0

D2986

Black Neoprene foam .125



Comment: Qty.: 5.9010 sf(s)/Unit Total: 5.9010 sf(s)

Pick:

Qty Part Number

Description

5.62SF D2986

Neoprene Foam

Batch

D30632

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

2-Attach Neoprene Foam using Contact Cement

A/R Contact Cement

Batch:

M102565

ml 07/08/16

x1

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07/08/16

16.0

A3235020935

Washer - Countersunk



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer - Countersunk

M104760

17.0

D35671

DECAL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

DECAL

batch:

D31127

ml 07/08/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer: CU-DAR001: Dart Helicopters Services

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Job Number: 33901

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS20426AD45

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Batch: M3459-



19.0

D35491

BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BRACKET

batch: B31125-



20.0

D2237

Striker Plate



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Batch: B31692-



21.0

D35547

BALL STUD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BALL STUD

batch: B30210-



22.0

AN960JD516

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Batch: M104156-



23.0

D30153

Lock Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Batch: B33423-



24.0

MS20426AD46

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Rivet

Batch: M100151-



EPD 07/08/15 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 33901

Part Number: D350600141

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	D35381	HINGE BRACKET
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

HINGE BRACKET

batch: B33968

x2

ml 07/09/11

26.0	D2179	Doubler
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Batch: B30630

EP

27.0	AN526C832R14	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

batch: M9216

28.0	AN960JD8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

batch: M104537

EP

29.0	MS21042L08	Nut
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

batch: M104812

EP

30.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3187-1 floor with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for body & floor*

n/a ml

31.0	D35529	CARBON STEEL GAS SPRING
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CARBON STEEL GAS SPRING

batch: B30673

EP

EP 07/08/150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 33901

Part Number: D350600141

Job Number:



Seq. #:	Machine Or Operation:	Description :
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32.0	MS270390811	Screw
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

* Screw
batch: M103585



33.0	AN960JD8	Washer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer
batch: M104537



34.0	NAS1515H3	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer
batch: M100993



35.0	MS21042L08	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut
batch: M104812



36.0	D2464	3/4 Seal
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Comment: Qty.: 11.3400 f(s)/Unit Total: 11.3400 f(s)

3/4 Seal
Cut 127.00" long batch: B30681



37.0	D2586	Door Latch
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Door Latch
batch: B32504



38.0	D2585	Latch Clamp
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Latch Clamp
batch: B33487



EP 07/08/150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 33901

Part Number: D350600141

Job Number:



Seq. #:	Machine Or Operation:	Description :
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39.0	D2621	Latch Plate
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Latch Plate

batch: 628916

EP



40.0	MS27039115	Screw
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Screw

batch: M105108

EP



41.0	AN960JD10	Washer
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Washer

batch: M104885

EP



42.0	MS21042L3	Nut
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Nut

batch: M104936

EP



43.0	D28571	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Hinge Bracket

batch: 631832

EP



44.0	D2228	Backing Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Backing Plate

batch: 630679

EP



45.0	AN526C832R10	Screw
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

batch: M104603

EP



07/08/150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001..Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 33901

Part Number: D350600141

Job Number:



Seq. #:	Machine Or Operation:	Description :
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46.0	AN960JD8	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Washer

batch: M104537-



47.0	MS21042L08	Nut
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Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Nut

batch: M104512-



48.0	D28572	Hinge Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Hinge Bracket

batch: 630718-



49.0	D35481	BRACKET
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BRACKET

batch: 630245-



50.0	D35547	BALL STUD
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

BALL STUD

batch: 630210-



51.0	AN960JD516	Washer
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

batch: M104156-



52.0	D30153	Lock Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lock Nut

batch: 633423-



07/08/150

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 33901

Part Number: D350600141

Job Number:



Seq. #:	Machine Or Operation:	Description :
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53.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600

Hardware on previous steps is for door ass'y*

ml 07/09/11 X1

54.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/13

55.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4

Batch: M105386

ml 07 09 14 ①

56.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: Inspect Wing Walk

MS / MM 07.09.14 ①

57.0	K10018	Spacepod Hardware Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 K10018

Spacepod Hardware Kit

D31805

1 D3187-1(Ref)

Spacepod Floor

B33901

Er 07/09/17

58.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

Er 07/09/17

59.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-600-141

Location:

PPP Rev: ①

Er 07/09/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 09/09/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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User: Linda Lacelle

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Customer: CU-DAR001..Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH

Job Number: 33901

Part Number: D350600141

Job Number:



Seq. #:

Machine Or Operation:

Description :

60.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

Done 09/19

Job Completion



u 09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

34

Date: Monday, 8/20/2007 3:01:17 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD ASSEMBLY LH
Job Number : 33901
Estimate Number : 10800
P.O. Number :
This Issue : 8/20/2007 S.O. No. : Part Number : D350600141
Prsht Rev. : NC Drawing Number : IIN REV.C PG11,18-21
First Issue : 8/15/2007 Type : SMALL /MED FAB Project Number : N/A
Previous Run : 33436 Drawing Revision : C
Material :
Written By : Due Date : 8/22/2007 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est Rev:D 05.04.14 Incorporated procedures from D3187-1/-2 K
J/JLM
Est Rev:E 06-11-20 As per DSI9335 JLM
est rev F 07.02.07 iin rev.c ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-600-141 CHG003

07.08 27

2.0 33901A SWITCH RELOCATION KIT



Comment: Sub-Component SWITCH RELOCATION KIT

3.0 33901B SPACEPOD BODY LH



Comment: Sub-Component SPACEPOD BODY LH

D3188-1M Batch: _____

4.0 33901C SPACEPOD DOOR LH



Comment: Sub-Component SPACEPOD DOOR LH

D3186-1 B _____

Job Completion



REFERENCE ONLY



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12085
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
09/08/2007	22/12/2006	5093	C. Lavoie		PO00002771		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	✓ 1	DKC134-0054	D3186-2M Spacepod Door RH B30085 U de M : Each Dwg. Rév.: D ✓ Job:41333			
1	0	✓ 1	DKC134-0055	D3188-2M Spacepod Body RH B30090 U de M : Each Dwg. Rév.: D ✓ Job: 41314			
1	0	✓ 1	DKC134-0052	D3186-1M Spacepod Door LH B30075 U de M : Each Dwg. Rév.: D ✓ Job: 41323			
1	0	✓ 1	DKC134-0053	D3188-1M Spacepod Body LH B30080 U de M : Each Dwg. Rév.: D ✓ Job: 41306			

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

[Signature]
Quality department AQ-357



Date: Jeudi, 2007-03-29 10:33:05
 Utilisateur: Marc Dubé

Feuille de Procédé

Cliant :	DART Dart Aerospace Ltd.	Nom Dessin :	SPACEPOD BODY
Numéro Job :	41306	Numéro Article :	DKC134-0053
Numéro Soumission :	2585	Numéro Dessin :	D3188
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-03-29	Révision dessin :	C
Prsht Rev. :	NC	Matériel :	Fibre 7781 et Résine 411-350
Prem. fois :	- -	Date Dûe :	2007-04-05
Job précédente :	41304	Qté:	1 Udm: UNITE



Écrit par : _____
Vérifié & Approuvé par : _____
Commentaires : N° de pièce Dart Aerospace : D31881M

Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie.

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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1.0	AC0303	Frekote 44NC
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Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
 Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
 PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 11/07/07 Heure Début: 10:15 Heure Fin: 12:00 Sceau:



3.0	AC0409	Tissu à délaminer Release ply B
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Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)
 Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
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Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)
 Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
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Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
 Feutre de drainage N° Airweave N 10

-6.0-	AC0752	Stretchlon 200 poche à vide Vert
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Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)
 Stretchlon 200 poche à vide Vert

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41306

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 11.400 VERGE(s)/Unit Total : 11.400 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish #LOT: 3-6093-1

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-5964-1

10.0 AAC0633 WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)

WR1850 ROVING 18 OZ x 50" N° de Lot: 1-6113-3

11.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 11/07/07 Heure Début: 12:30 Heure Fin: 4:30



12.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)

Catalyst N° DDM-9 N° de Lot: 1-5921-3

13.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6228-1

14.0 AAC0673 Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)

Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

15.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41306

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxxy 66.

Date: JUL 12 2007

Heure Début: 10:15

Heure Fin: 10:30

Sceau:



16.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz. et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

JUL 12 2007

Date:

Heure Début: 10:30

Heure Fin: 11:15

Sceau:



17.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Film Perforé P-3
- 3- Feutre de drainage.
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

JUL 12 2007

Date:

Heure Début: 11:15

Heure fin: 11:35

Sceau:



Curing Début: 10:30 Curing Fin: 4:00

18.0

AAC0457

ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total: 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 3-3915-2

Date: Jeudi, 2007-03-29 10:33:06

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41306

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

19.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler et le Foam Core 1" selon plan de découpe et gabarits

Date: JUL 30 2007

Heure Début: 10:15

Heure Fin: 12:06

Sceau:



20.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

1-6228-1

21.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)
Catalyst N° DDM-9

N° de Lot:

1-5921-3

22.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

JUL 13 2007



Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

23.0

AAC0452

Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)
Polybond B46F

N° de Lot:

1-6177-1

24.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

À l'aide de polybond, coller ensemble les deux surfaces scellées

Disposer des poids sur les pièces pour conserver une pression de collage.

Laisser sécher 2 heures minimum.

Quantité: /

JUL 13 2007

Date:

Sceau:



Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41306

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Quantité: _____ Date: _____ Sceau: _____

25.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster à l'aide du thermoformeur 4" x 8" chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: JUL 30 2007 Sceau:

Quantité: _____ Date: _____ Sceau: _____

26.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6228-1

27.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-5921-3

28.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL DART

JUL 30 2007



Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350 promu 75 minutes..

29.0

FAB GÉNÉRALE 3

FABRICATION GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
FABRICATION GÉNÉRALE DART

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promu N° 411-350 75 minutes. Selon I.G. # Sceller le Foam Core

Laisser sécher pendant 2 heures minimum.

Date: JUL 30 2007 Sceau: Initiales: C.G.

Date: Jeudi, 2007-03-29 10:33:06

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41306

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération:

Description :

30.0 AAC0452 Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total: 0.078 KIT(s)
Polybond B46F N° de Lot: 1-6177-1

31.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation du Polybond.

Date: JUL 31 2007

Heure Début: 8:10

Heure Fin: 8:20

Sceau:



32.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

ASSEMBLAGE GÉNÉRALE DES PIÈCES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: JUL 31 2007

Heure Début: 8:20

Heure Fin: 8:40

Sceau:



33.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Feutre de drainage
- 3- Sac à vide Stretchlon 200

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ci ne soit complètement polymérisé

Date: JUL 31 2007

Heure Début: 8:40

Heure Fin: 9:00

Sceau:



Curing: Début: 8:20 Curing Fin: 9:30

34.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total: 0.100 UNITE(s)

Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6227-1

Date: Jeudi, 2007-03-29 10:33:06

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41306

Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

35.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

36.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plos gros défauts, utiliser du polybond.

Date: JUL 31 2007 Heure Début: 12:30 Heure Fin: 3:00 Sceau:

37.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

JUL 31 2007



Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule.

38.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6228-1

39.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

40.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core

Laisser sécher pendant 2 heures minimum.

Quantité: 1 Date: AUG 10 2007 Sceau:

Quantité: 1 Date: AUG 01 2007 Sceau:

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41306

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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41.0	AAC0275	Catalyst N° DDM-9
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Commentair Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-618-3

42.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6228-1

43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: AUG 01 2007 Heure Début: 10:15 Heure Fin: 10:25 Sceau:

44.0	LAMINAGE.	LAMINAGE PIÈCE DART
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Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: AUG 01 2007 Heure Début: 10:25 Heure Fin: 11:05 Sceau:

45.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41306

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

Date: AUG 01 2007Heure Début: 11:05 Heure Fin: 11:25 Sceau:Curing Début: 10:25 Curing Fin: 3:00

46.0

DÉMOULAGE 1

DÉMOULAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIECES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: AUG 01 2007Heure Début: 3:15 Heure Fin: 3:45 Sceau:

47.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.

Par l'intérieur, percer les 8 dégagement de $\varnothing .745"$ pour les spacers. (Ne pas percer la peau extérieur de la pièce)

Date: AUG 01 2007Heure Début: 3:45 Heure Fin: 4:30 Sceau:

48.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-6118-3

49.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6228-1

50.0

AAC0673

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41306

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

51.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: AUG 03 2007

Heure Début: 16:15 Heure Fin: 16:25 Sceau:



52.0

AAC0448

Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)
Spacer N° D2213 N° de Lot: 1-5949-1

53.0

ASSEMBLAGE 3

ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre Miapoxy 66

Laminer une pièce de 9 oz. sur chacune des 2 zones de 4 spacers pour reboucher les trous.

Appliquer un pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autobloquantes.

Laisser sécher pendant 4 heures minimum.

Date: AUG 03 2007

Heure Début: 10:25 Heure Fin: 11:00 Sceau:



Curing Début: 10:25 Curing Fin: 8:00

54.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 1-618-3

55.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-628-1

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41306

Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description:

56.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par
quantité de résine N° 411-350.

Date: AUG 02 2007 Heure Début: 3:15 Heure Fin: 3:20 Sceau:

57.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et les blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 sur le contour de la pièce selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: AUG 02 2007 Heure Début: 3:20 Heure Fin: 4:30 Sceau:

Curing Début: 3:20 Curing Fin: 8:00

58.0

FINITION 3

FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

2 Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

/ Percer les 8 trous des spacers afin de les déboucher.

Quantité: 1 Date: 06-8-07 Sceau:

Quantité: 1 Date: 06-8-07 Sceau:

59.0 AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total: 0.5000 GALLON(s)
Dupont Primer N° 1104S

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41306Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:



Séq.: Machine ou Opération: Description :

60.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activator N° 7975S

61.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S

62.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

AUG 06 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0 PEINT/PRIMER2 PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

Date: AUG 06 2007

Heure Début: 3:15 Heure Fin: 4:30 Sceau:

64.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6227-1

65.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

66.0 FINITION 3 FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage (grit 220) de toutes les surfaces.

Date: 07/8/07 Heure Début: 11:30 Heure Fin: 3:30 Sceau:

Jeudi, 2007-03-29 10:33:06

eur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aérospace Ltd.

Nom Dessin: SPACEPOD BODY

Numéro Job: 41306

Numéro Article: DKC134-0053

Numéro Job:



Séq.:

Machine ou Opération:

Description :

67.0

AAC0671

Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)

Dupont Primer N° 1104S

N° de Lot: 1-6065-2

68.0

AAC0670

Dupont Activator N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)

Dupont Activator N° 7975S

N° de Lot: 1-6065-1

69.0

AAC0672

Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot: 1-6065-3

70.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

PRÉPARATION DU MATÉRIEL

AUG 07 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

71.0

PEINT/PRIMER2

PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un minimum de 3 heures.

Date: AUG 07 2007 Heure Début: 3:15 Heure Fin: 4:00 Sceau:



72.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 8-08-07 Sceau: QA-11 Initiales: H.S.



Emballage QT 1 8/8/07



Date: Jeudi, 2007-03-29 10:33:59
Utilisateur: Marc Dubé

Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: SPACEPOD DOOR
Numéro Job	: 41323		Numéro Article	: DKC134-0052
Numéro Soumission	: 2584		Numéro Dessin	: D3186
Numéro B.A.	:		Projet Numéro	: DKC134
Cette fois	: 2007-03-29	No. B.V. :	Révision dessin	: C
Prsht Rev.	: NC		Matériel	: Fibre 7781 et Résine 411-350
Prem. fois	: - -	Type :	Date Dûe	: 2007-04-05
Job précédente	: 41322		Qté:	1 Udm: UNITE

Écrit par : _____

Vérifié & Approuvé par : _____

Commentaires : N° de pièce Dart Aerospace : D31861M



Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AC0303	Frekote 44NC
-----	--------	--------------


Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
-----	---------------	------------------------------



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: JUN 21 2007 Heure Début: 12:30 Heure Fin: 2:00 Sceau: 

3.0	AC0409	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Feutre de drainage N° Airweave N.10.

6.0	AC0752	Stretchlon 200 poche à vide Vert
-----	--------	----------------------------------

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Date: Jeudi, 2007-03-29 10:33:59

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41323

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

7.0 AAC0681 9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total: 4.500 VERGE(s)

9.7 oz Weave #FG-778150-125Y Volan Finish #LOT: 1-6170-2

8.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total: 2.2500 RL(s)

Ruban à gommer jaune #: T/AT-200Y

9.0 AAC0443 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total: 1.00 VERGE CAR(s)

Fiberglass 12 oz Unidirectional N° de Lot: 1-5964-1

10.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 4/06/07 Heure Début: 8:00 Heure Fin: 10:00 Sceau:



11.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0080 PINTE(s)/Unit Total: 0.0080 PINTE(s)

Catalyst N° DDM-9 N° de Lot: 1-5921-3

12.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total: 0.500 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6167-1

13.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 21 2007 Heure Début: 12:30 Heure Fin: 12:40 Sceau:



Date: Jeudi, 2007-03-29 10:33:59

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41323

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

14.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: JUN 21 2007

Heure Début: 12:40

Heure Fin: 12:55

Sceau:



15.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: JUN 21 2007

Heure Début: 12:55

Heure Fin: 1:05

Sceau:



Curing Début: 12:40

Curing Fin: 8:00

16.0

AAC0275

Catalyst N° DDM-9

Commentaire Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

17.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentaire Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6167-1

Date: Jeudi, 2007-03-29 10:33:59
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41323

Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: JUN 26 2007 Heure Début: 10:15 Heure Fin: 10:30 Sceau:



19.0	DKC134-0056	Foam Core N° D3186-101 (Porte D3186-1)
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Commentaire Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Foam Core N° D3186-101 (Porte D3186-1)

#LOT 1-5826-1

20.0	AAC0452	Polybond B46F
------	---------	---------------

Commentaire Qty.: 0.082 KIT(s)/Unit Total: 0.082 KIT(s)

Polybond B46F

N° de Lot:

1-6177-1

21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART
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Commentaire Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: JUN 27 2007 Heure Début: 8:00 Heure Fin: 8:30 Sceau:



22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
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Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer
- 2- Feutre de drainage

Date: Jeudi, 2007-03-29 10:33:59

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41323

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond.

Date: JUN 27 2007

Heure Début: 8:30

Heure Fin: 8:50

Sceau:



Curing Début: 8:00

Curing Fin: 9:30

23.0

AAC0275

Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit

Total : 0.0400 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 1-5921-3

24.0

AAC0324

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit

Total : 1.000 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6167-1

25.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: JUN 27 2007

Heure Début: 3:30

Heure Fin: 3:30

Sceau:



26.0

LAMINAGE.

LAMINAGE PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte .

Faire le laminage du dernier pli de 9.7 oz.

Date: 27-6-07

Heure Début: 3:30

Heure Fin: 4:05

Sceau:



Date: Jeudi, 2007-03-29 10:33:59

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41323

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

27.0

POCHE À VIDE 1

FAIRE LA POCHE À VIDE





Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

- 1- Tissu à délaminer,
- 2- Film perforé P-3,
- 3- Feutre de drainage
- 4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 27-6-07 Heure Début: 4:05 Heure Fin: 4:15 Sceau:  

Curing Début: 3:30 Curing Fin: 8:00

28.0

DÉMOULAGE 1



DÉMOULAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
DÉMOULAGE DES PIÈCES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci

Date: JUN 28 2007 Heure Début: 7:35 Heure Fin: 7:45 Sceau:  

29.0


TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TRIMAGE DE FINITION

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: JUN 28 2007 Heure Début: 8:00 Heure Fin: 8:30 Sceau: 

30.0 AAC0671

Dupont Primer N° 1104S

Commentaire Qty.: 0.1390 GALLON(s)/Unit Total: 0.1390 GALLON(s)
Dupont Primer N° 1104S 1-6149-1

Date: Jeudi, 2007-03-29 10:33:59

Utilisateur: Marc Dubé

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41323

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

31.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S 1-6065-1

32.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S 1-6065-3

33.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

Nettoyage Qty 1 10-07-07



JUL 10 2007



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.



01/08/07

34.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer la première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. #
Application du primer.

Laisser sécher pendant 3 heures.

01/08/07



Date: JUL 10 2007

Heure Début:

Heure Fin:

Sceau:



35.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les imperfections et enlever le lustre du primer.

36.0 AC0058 Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

Date: Jeudi, 2007-03-29 10:33:59

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

Numéro Job: 41323

Numéro Article: DKC134-0052

Numéro Job:



Séq.: Machine ou Opération: Description :

37.0 AAC0646 MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.050 KIT(s)/Unit Total : 0.050 KIT(s)
MASTIC POLYSTOP SIKKENS 3AR591

38.0 AC0059 Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens N° de Lot: 1-6079-1

39.0 FINITION 3 FINITION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FINITION GÉNÉRALE

Rework 08807



Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 12-7-07 Heure Début: 12:30 Heure Fin: 14:30 Sceau:

40.0 AAC0671 Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-6149-1

41.0 AAC0670 Dupont Activator N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-6065-1

42.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-0149-2

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

AUG 0 8 2007



IL

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

44.0 PEINT/PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
APPLICATION DE PRIMER

Appliquer la deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. #

Application du primer

2002 8 0 9H
AUG 0 8 2007

Date: 5:15 Heure Début: 5:30 Heure Fin: Sceau:

Date: Jeudi, 2007-03-29 10:33:59
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: SPACEPOD DOOR

• Numéro Job: 41323

Numéro Article: DKC134-0052

Numéro Job:



Séq.:

Machine ou Opération:

Description :

45.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

INSPECTION PIÈCE DART

Qty: 1



9-08-07 H.S.

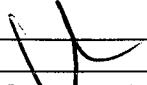

Emballage QT 1

9/8/07



Date Wednesday, 15/08/2007 9:51:20 AM
 User Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACEPOD DOOR LH
Job Number : 33901C01	
Estimate Number : 12598	
P.C. Number :	Part Number : D31861M
This Issue : 15/08/2007 S.O. No. :	Drawing Number : D3186 REV.D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 33438B01	Material :
Written By : 	Due Date : 22/08/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est Rev A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: _____

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

See w/o 30075

2.0

D31861P

Spacepod Door

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Spacepod Door

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186. Visual inspection. Check for void spot and pins. Ensure surface of doo is smooth, no dimples for drilling.

Date: Wednesday, 15/08/2007 9:51:20 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 33901C01

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Date Wednesday, 15/08/2007 9:46:36 AM
 User Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACEPOD BODY LH
 Job Number : 33901B
 Estimate Number : 12595
 P.C. Number :
 This Issue : 15/08/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D31881M
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3188 REV.E
 Previous Run : 33438A Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 22/08/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev A New issue ecn882 06-11-30 EC
 est rev B revc dwg 07.01.11 ec
 est rev C revD dwg 07.03.07 ec
 est rev D rev E dwg 07.04.16 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2213 Aluminum Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Ship To Delastek

8 D2213 Spacer Batch: _____

see w/d 30080

2.0 PG PURCHASING



Comment: PURCHASING
 Issue P/O: _____
 Description: D3188-1M BODY
 Ship: D2213 Spacers
 Supplier: Delastek
 Conformity Certificate and Process sheet required
 Ship 2 Items from Previous steps

3.0 D31881P Spacepod Body



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Spacepod Body

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 15/08/2007 9:46:36 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 33901B

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 57-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/21/2006 12:54:56 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SPACEPOD BODY LH
Job Number :	30080		
Estimate Number :	12595		
P.O. Number :	N/A	Part Number :	D31881M
This Issue :	12/21/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3188 REV <i>BC</i> <i>LE</i> 07.01.18
First Issue :	N/A	Project Number :	N/A
Previous Run :	30079	Drawing Revision :	<i>BC</i> <i>LE</i> 07.01.18
	Type :	Material :	N/A
	PURCHASED PARTS	Due Date :	2/15/2007
Written By :		Qty:	1
Checked & Approved By :	<i>JA</i> 061221	Um:	Each
Comment :	Est Rev:A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D2213	Aluminum Spacer
-----	-------	-----------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Ship To Delastek

8 D2213 Spacer Batch: *B30049*

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2771*

Description: D3188-1 BODY

Ship: D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from Delastek is attached.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 21/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/21/2006 12:54:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD BODY LH

Job Number: 30080

Part Number: D31881M

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

ml 07/08/15

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 07/08/15

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
D 07/09/19

Job Completion



u 07-09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CE	REV. C	
CHECKED PH	APPROVED PH	DRAWING NO. D3188	SHEET 1 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS
A	03.04.03	NEW ISSUE	
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	
C	06.12.13	REMOVED D0600-XXX LABELS	

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

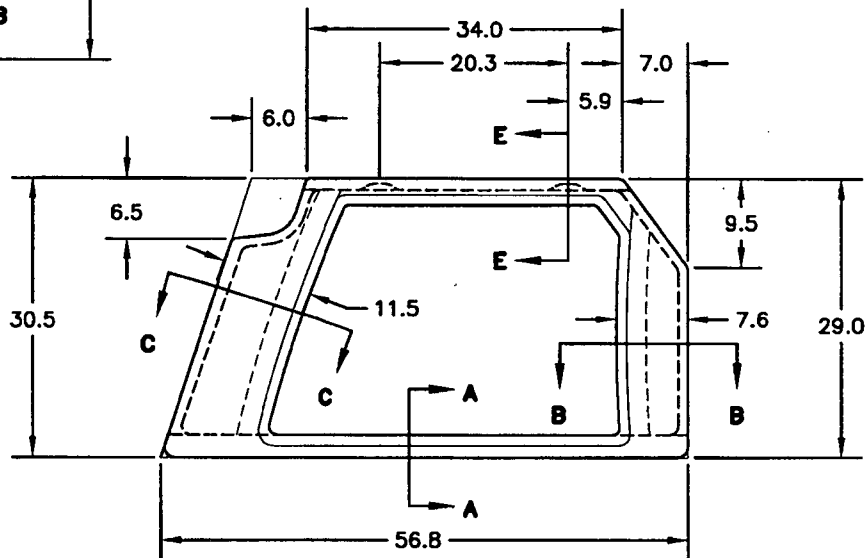
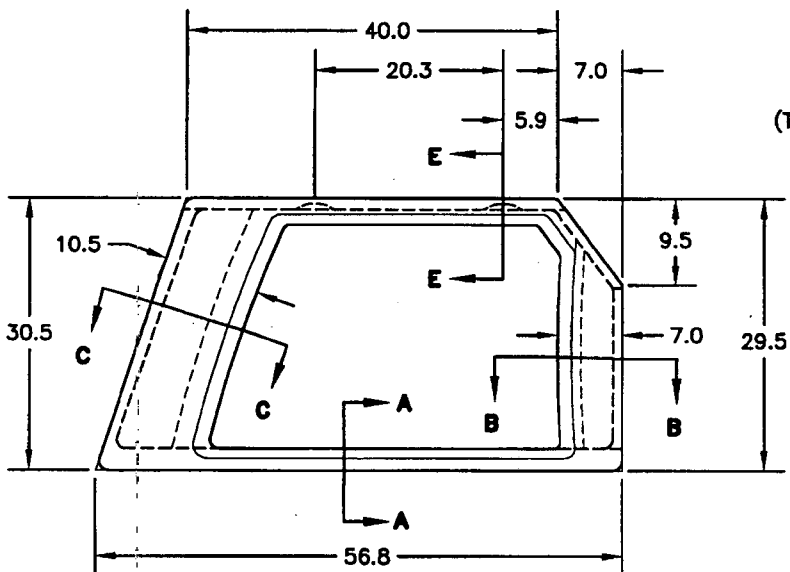
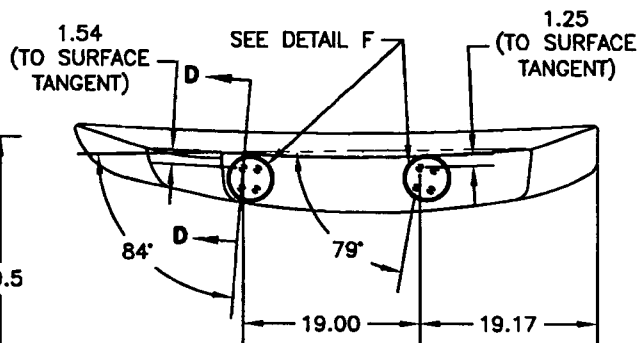
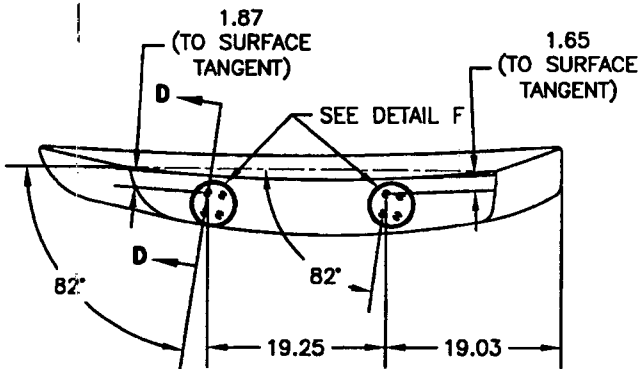
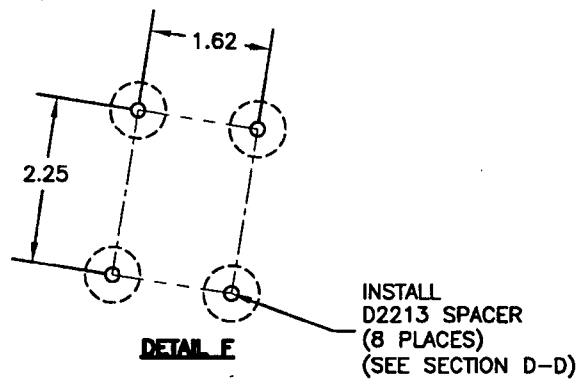
5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES
8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
06.12.22

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WORK ORDER

DART

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DATE	06.12.13	DRAWING NO.	D3188	REV. C
		TITLE	SPACEPOD BODY	SHEET 2 OF 11
		SCALE	NTS	



D3188-1M SPACEPOD BODY

D3188-3M SPACEPOD BODY

RELEASED

NOTE: SEE SHEET #4 FOR SECTION VIEWS

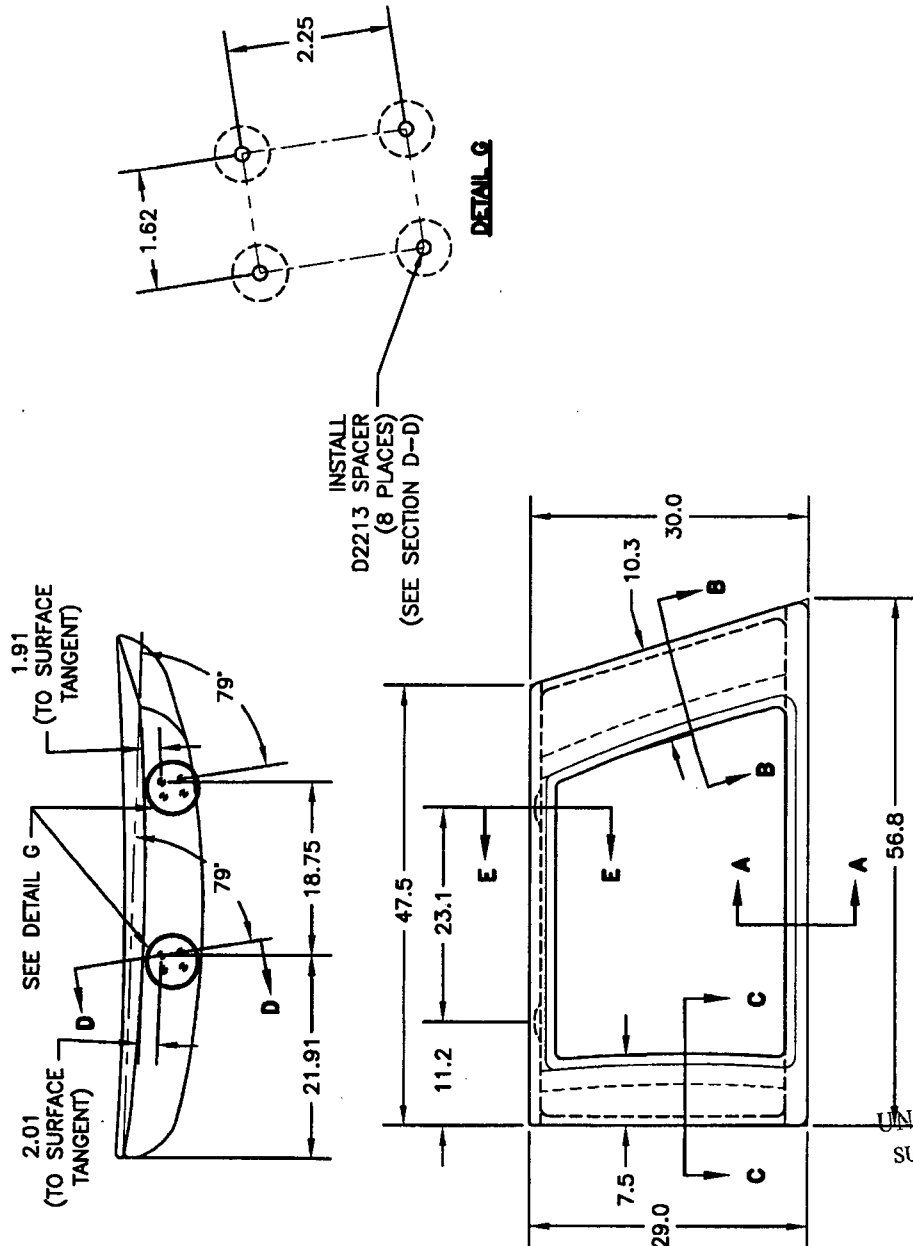
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS



D3188-2M SPACEPOD BODY

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06.12.22 *[Signature]*

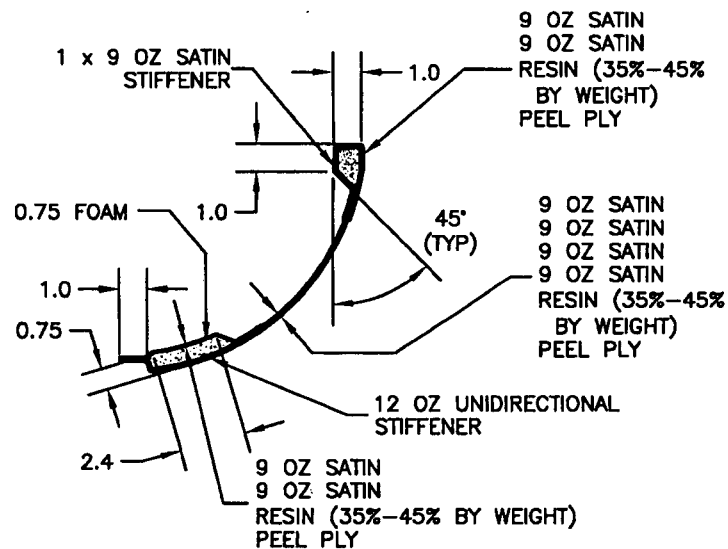
NOTE:
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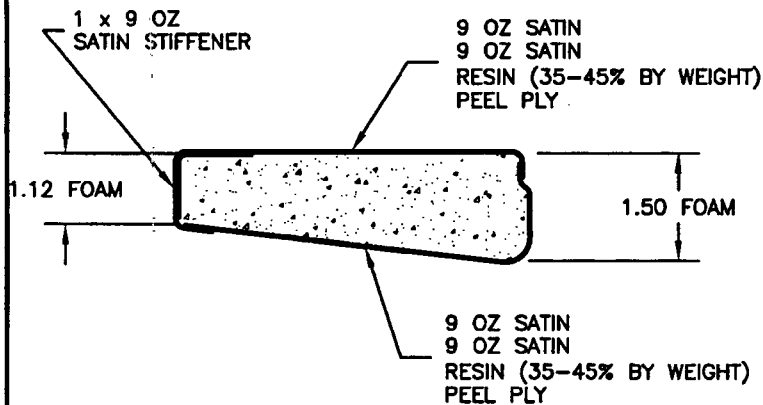
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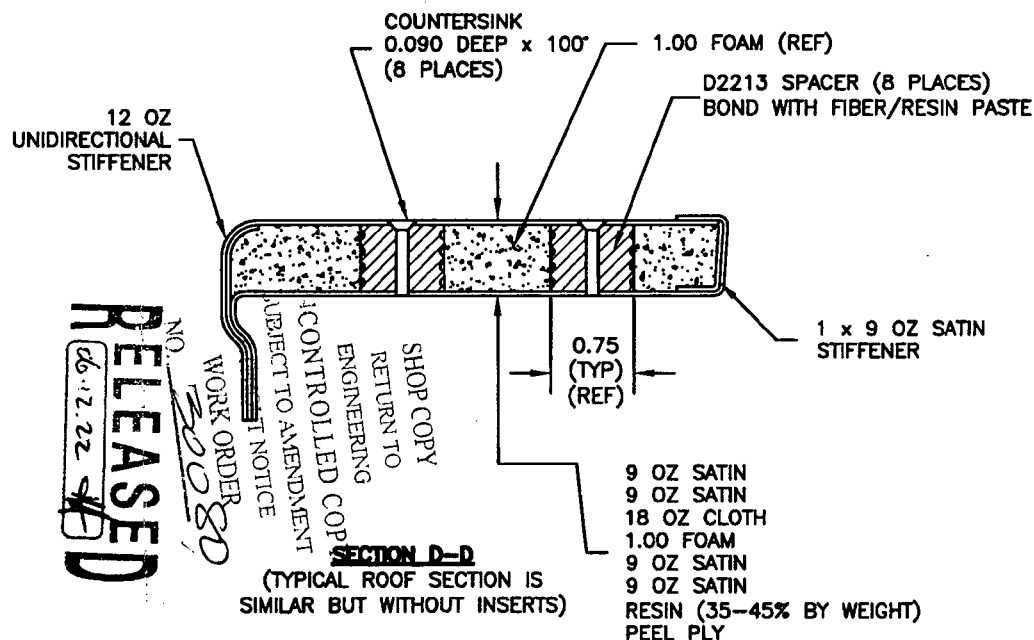
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CHECKED	PH	APPROVED	PH	DRAWING NO.	D3188	SHEET 4 OF 11
DATE	06.12.13	TITLE	SPACEPOD BODY			SCALE N/S



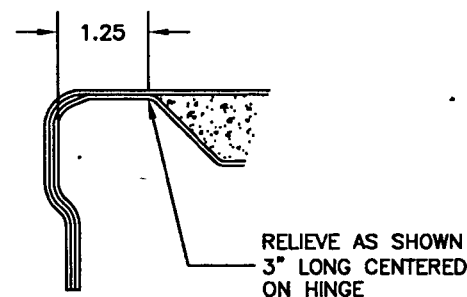
SECTION B-B
(SECTION C-C OPPOSITE)



SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

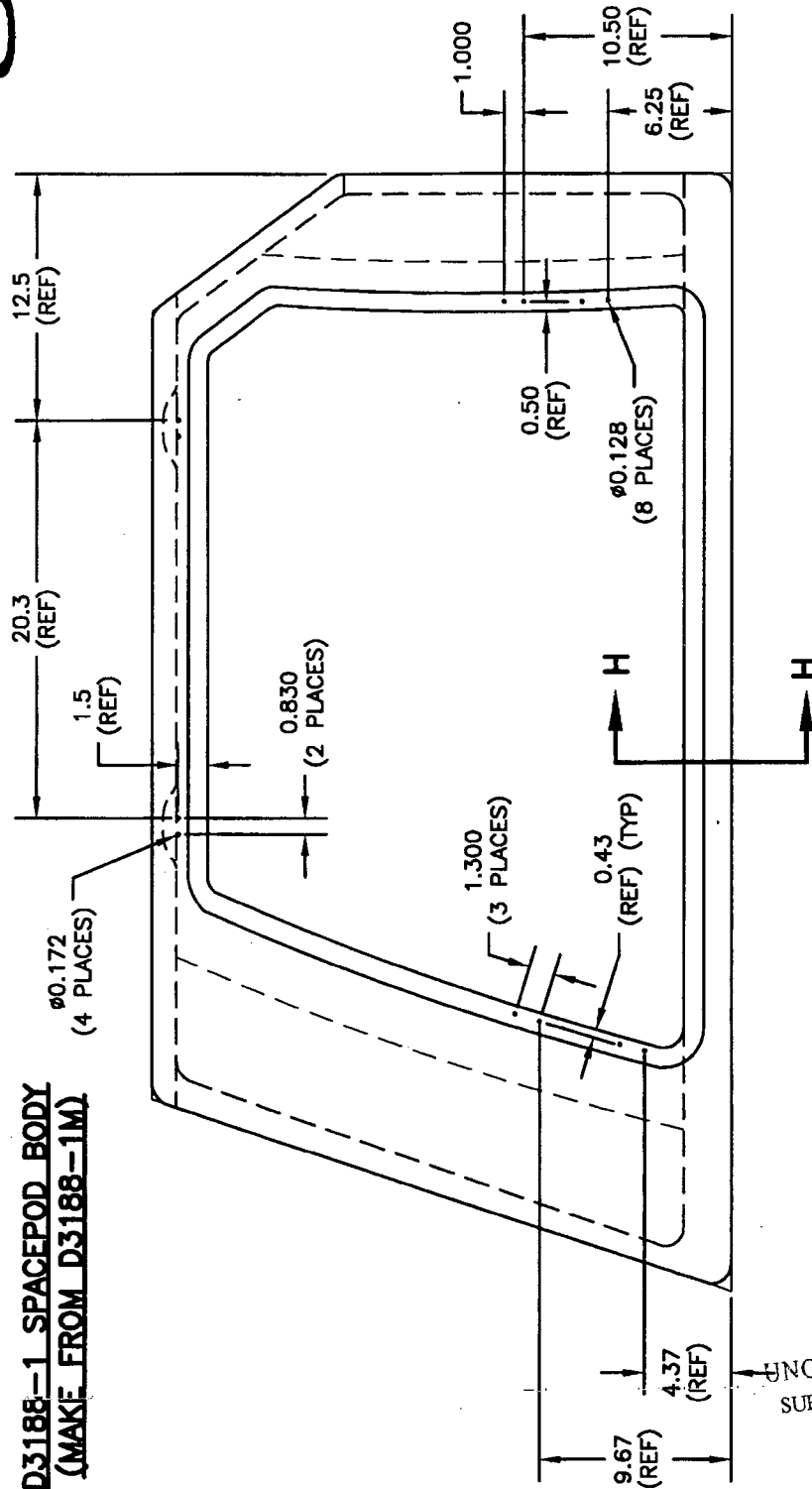
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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**D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)**

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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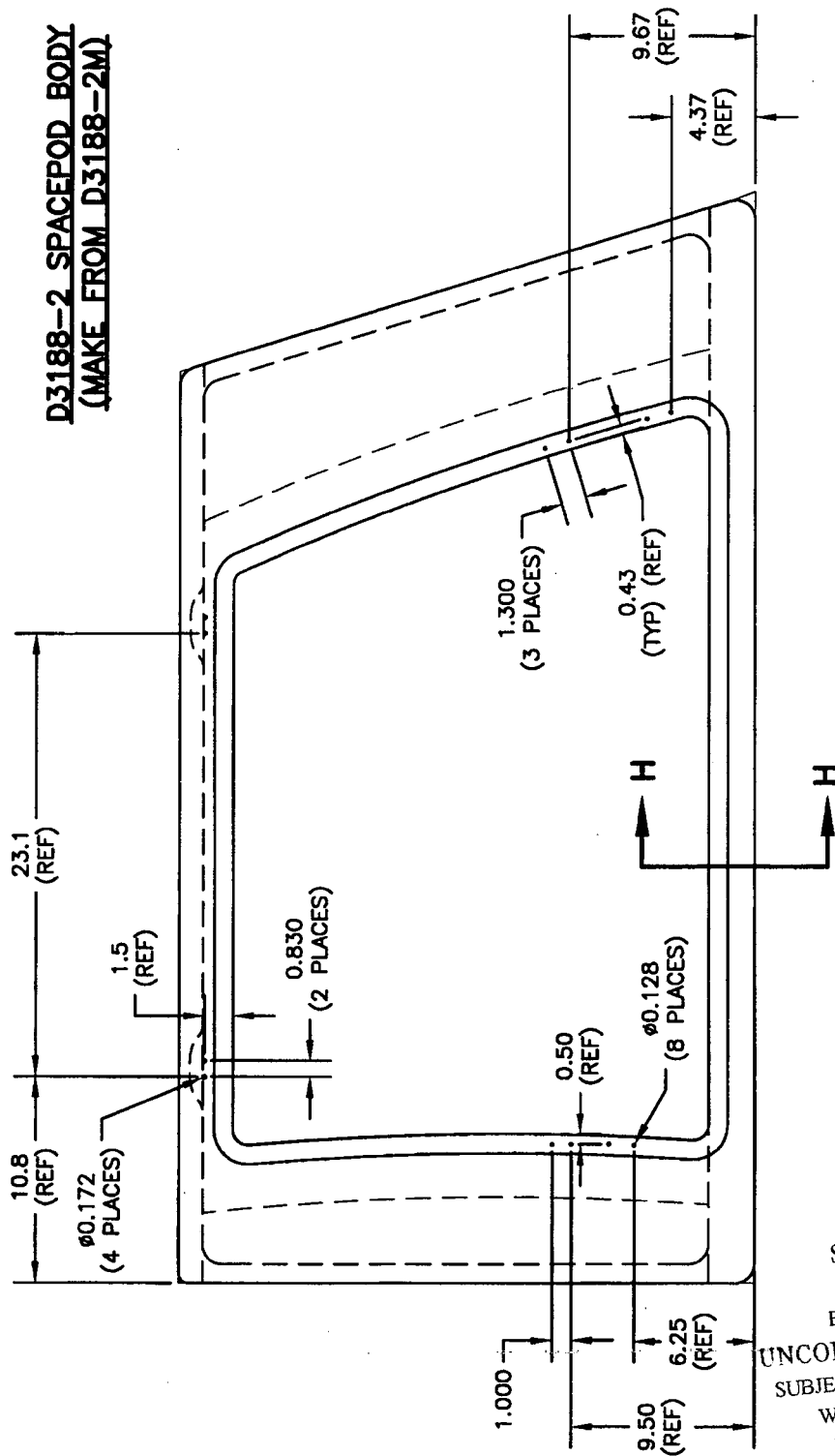
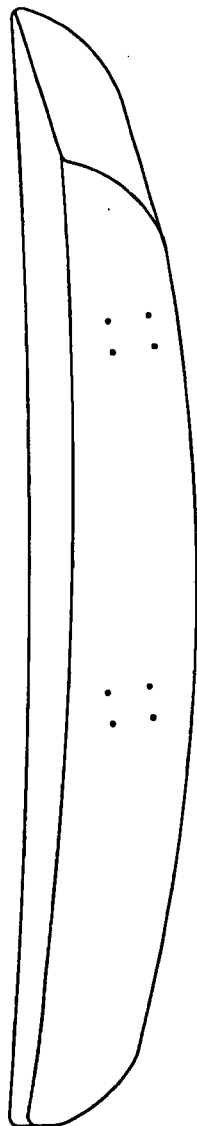
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22

**D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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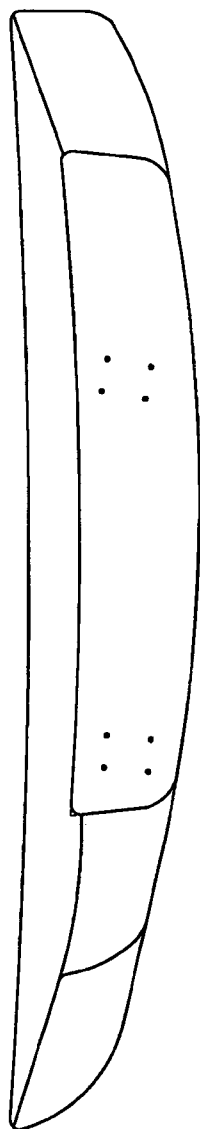
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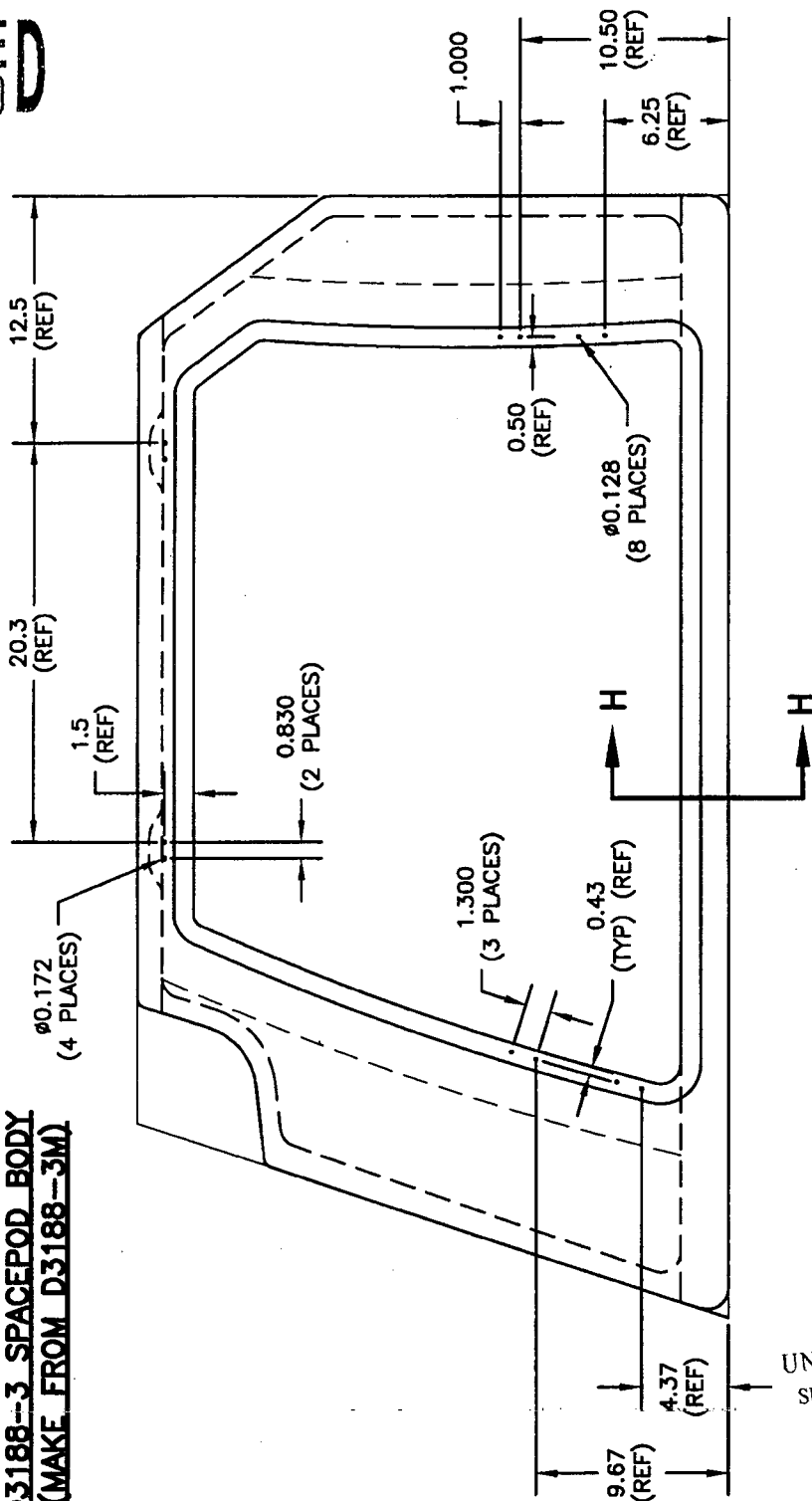


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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

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06.12.22



**D3188--3 SPACEPOD BODY
(MAKE FROM D3188--3M)**



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186--1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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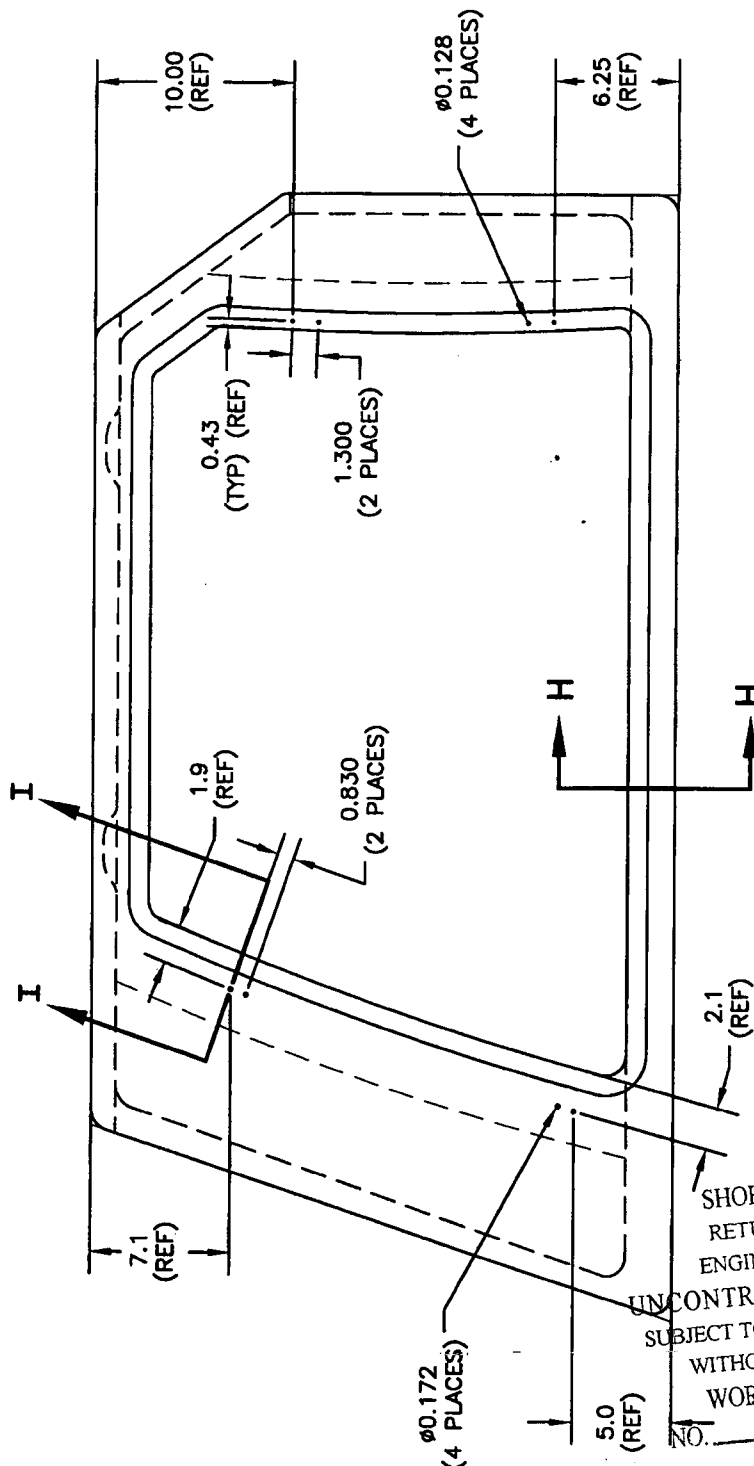
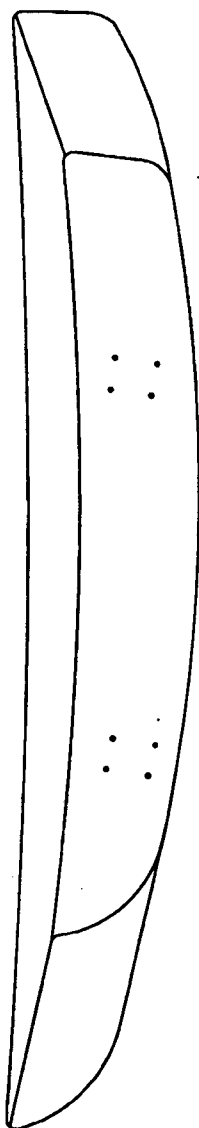
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-5 SPACEPOD BODY
(MAKE FROM D3188-1M)



- NOTES:
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
 - 2) SEE SHEET #11 FOR SECTION VIEWS

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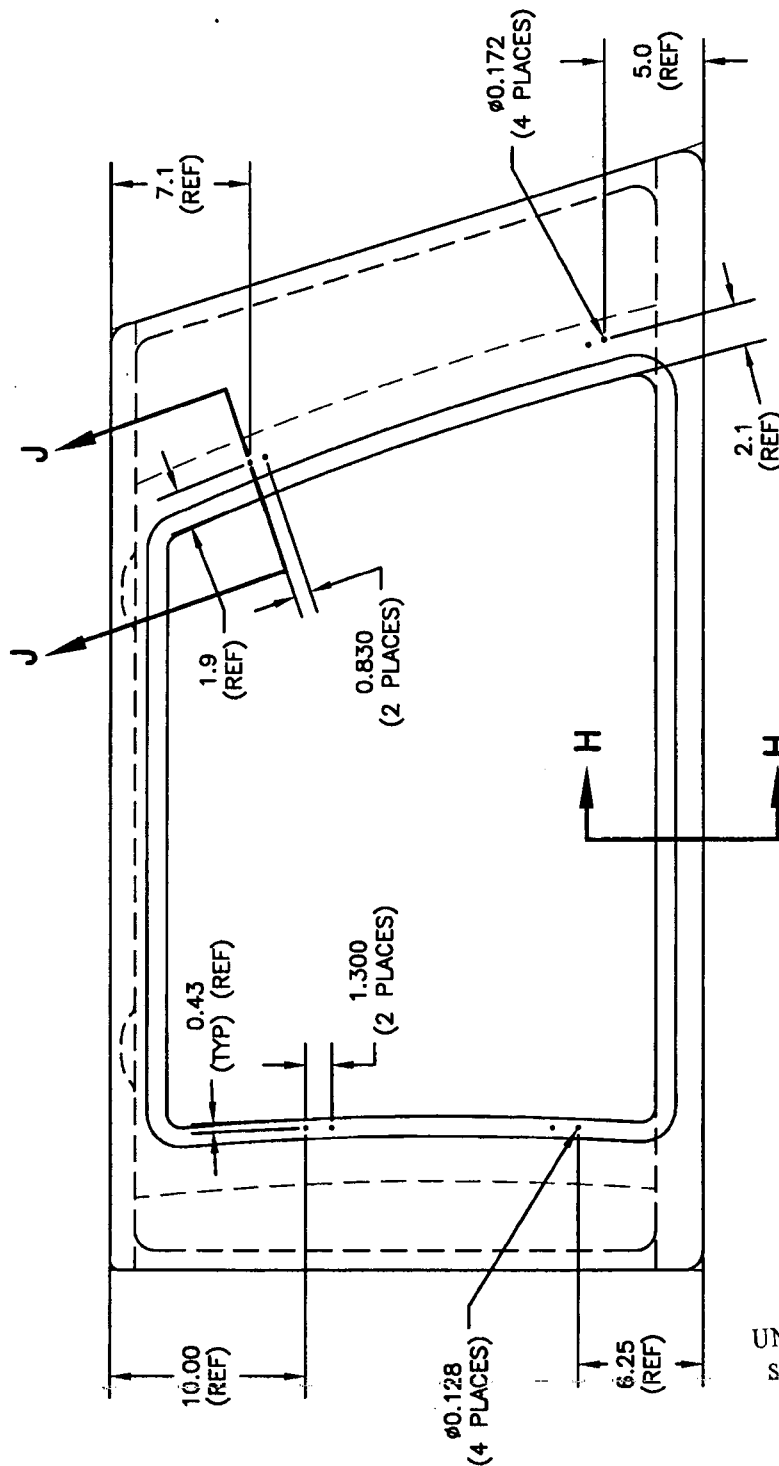
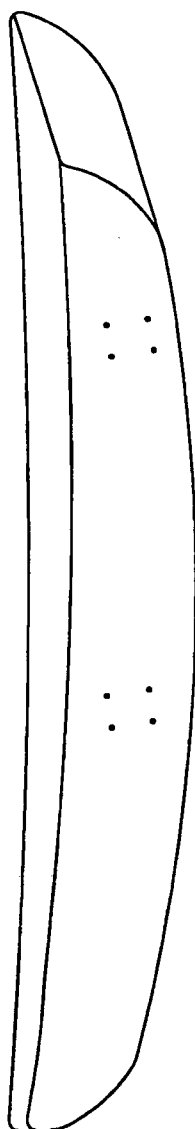
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
06.12.22

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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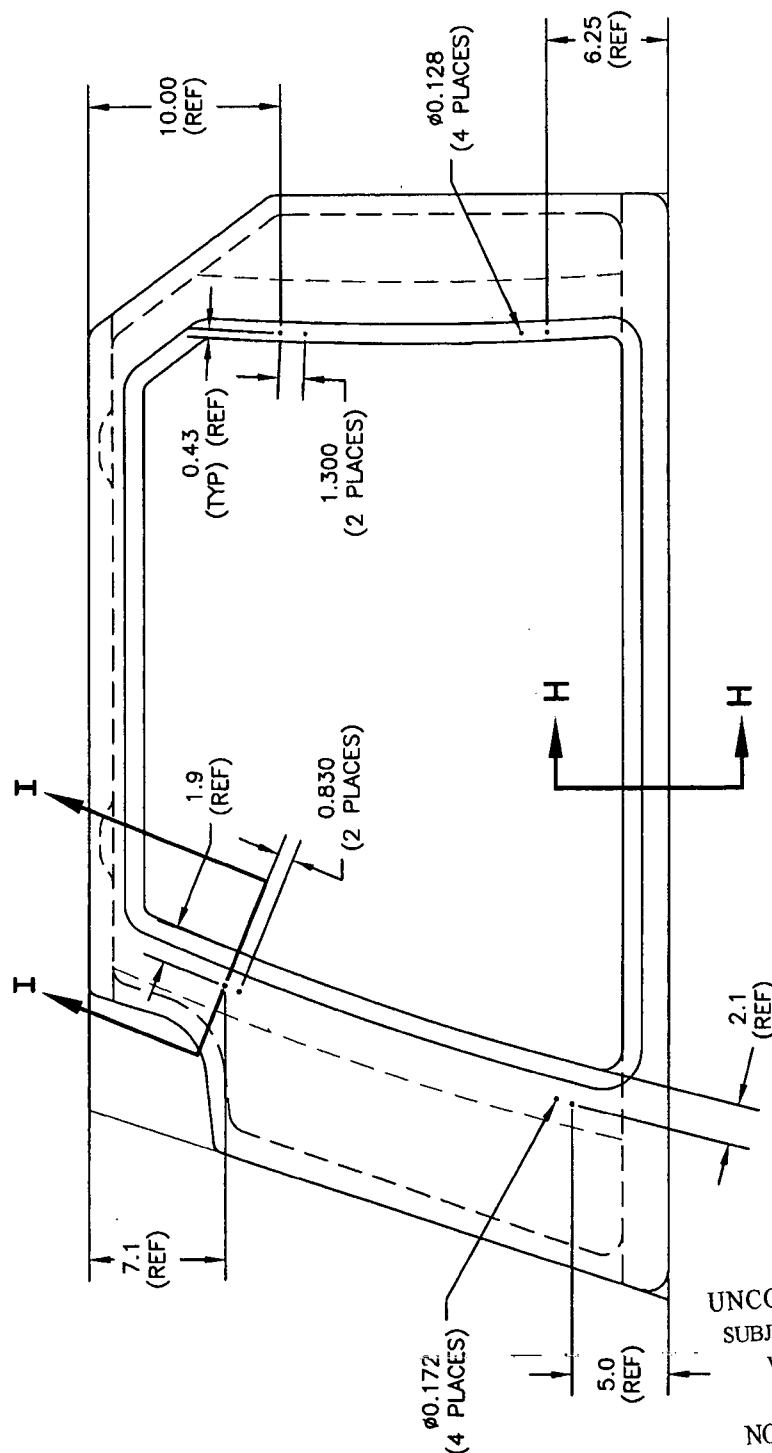
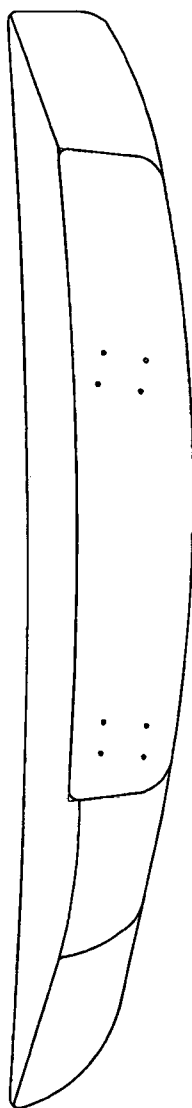
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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

RELEASED
0.2.22

D3188-7 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DATE 06.12.13	TITLE SPACEPOD BODY		SCALE NTS

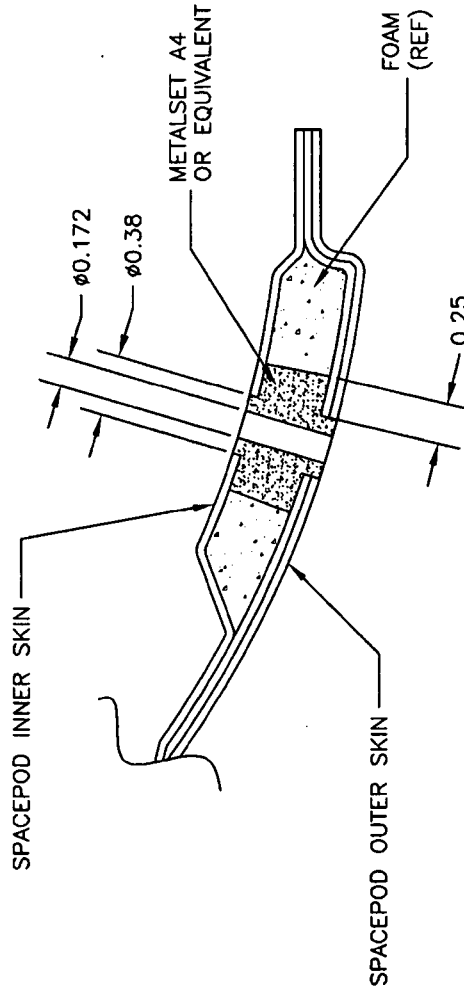
RELEASED
06.12.22

INSTALL AKS7-1032-130
INSERTS (29 PLACES)
PER D3188-1T1 (D3188-1/-3/-5/-7)
OR D3188-2T1 (D3188-2/-6)

FOAM
(REF)



SECTION H-H
(TYPICAL FLOOR SECTION)



SECTION I-I
(SECTION J-J OPPOSITE)
(4 PLACES PER POD)

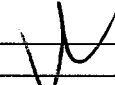
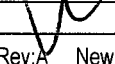
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WORK ORDER
NO. 30080

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Date Wednesday, 15/08/2007 9:46:37 AM
User Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 33901C		
Estimate Number	: 11095		
P.C. Number	: N/A	Part Number	: D31861
This Issue	: 15/08/2007 S.O. No. : A/A	Drawing Number	: D3186 REV.D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 33436C	Material	: N/A
Written By	: 	Due Date	: 22/08/2007 Qty: 1 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:A New Issue 05-11-29 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	33901C01	SPACEPOD DOOR LH
-----	----------	------------------



Comment: Sub-Component SPACEPOD DOOR LH

2.0	SMALL FAB 1 <i>w/o 30095</i>	SMALL & MEDIUM FAB RESOURCE 1
-----	------------------------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill holes and cut out latch slots per dwg D3186 (D3186-1 detail)

ml 07/08/16 (x1)

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/16

4.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

ml 07/08/16 (x1)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

ml 07/08/16 (x1)

Job Completion



U 07-09-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

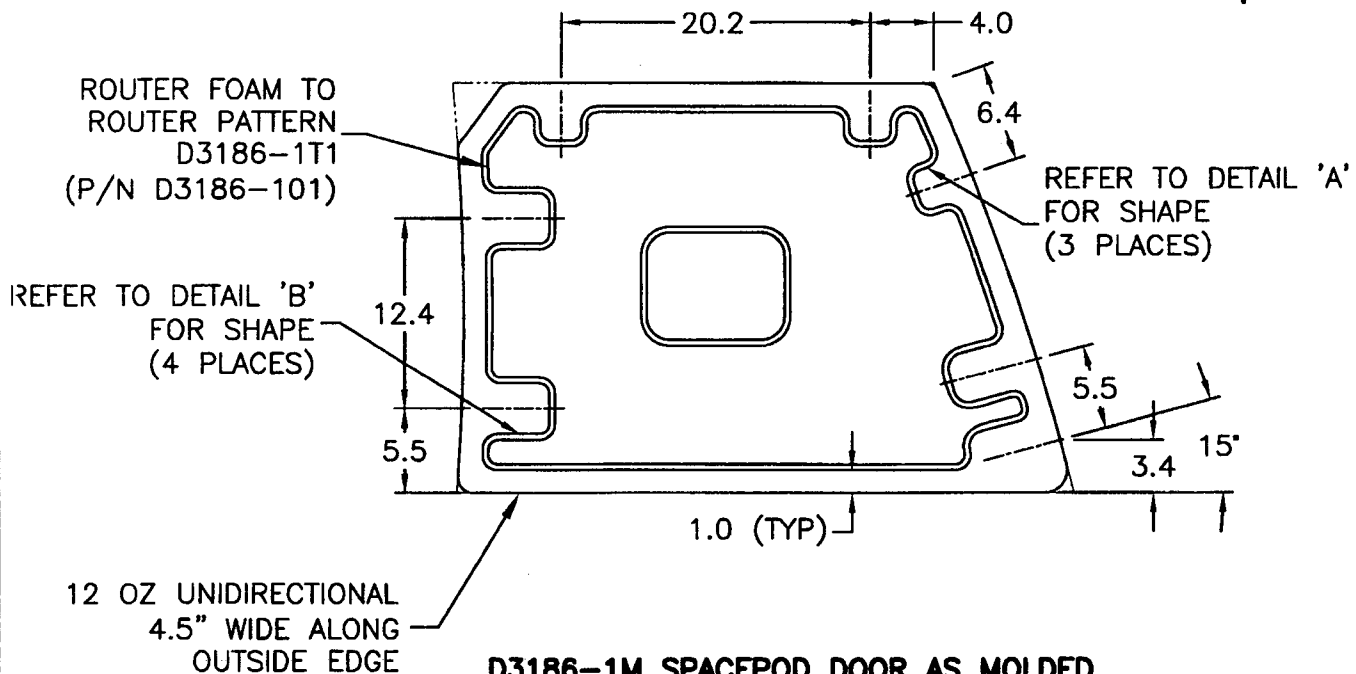
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR	SCALE NTS	
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	
D	07.02.22	UPDATE DIMENSIONS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED07.02.27 *H***D3186-1M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

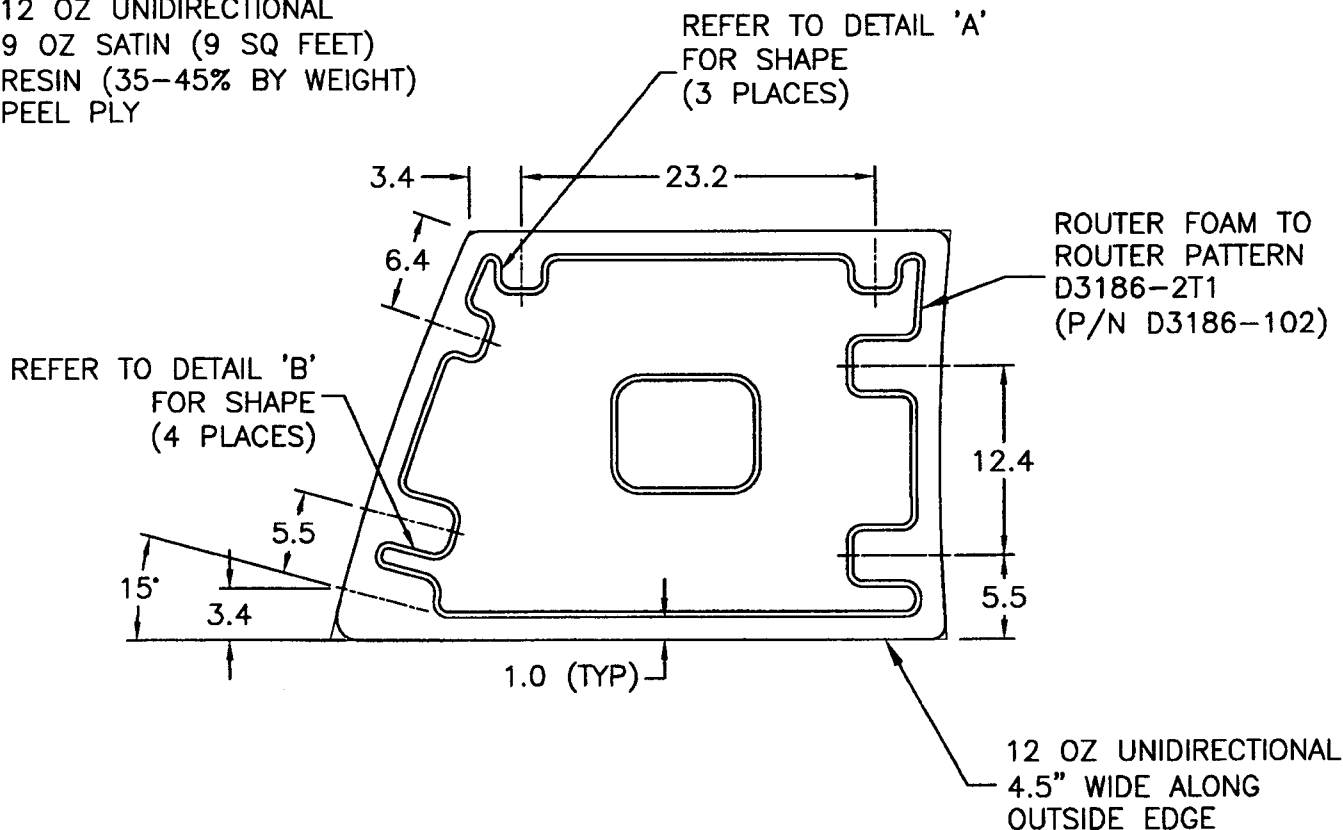
DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED

07.02.27 H

**D3186-2M SPACEPOD DOOR AS MOLDED****NOTES:**

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

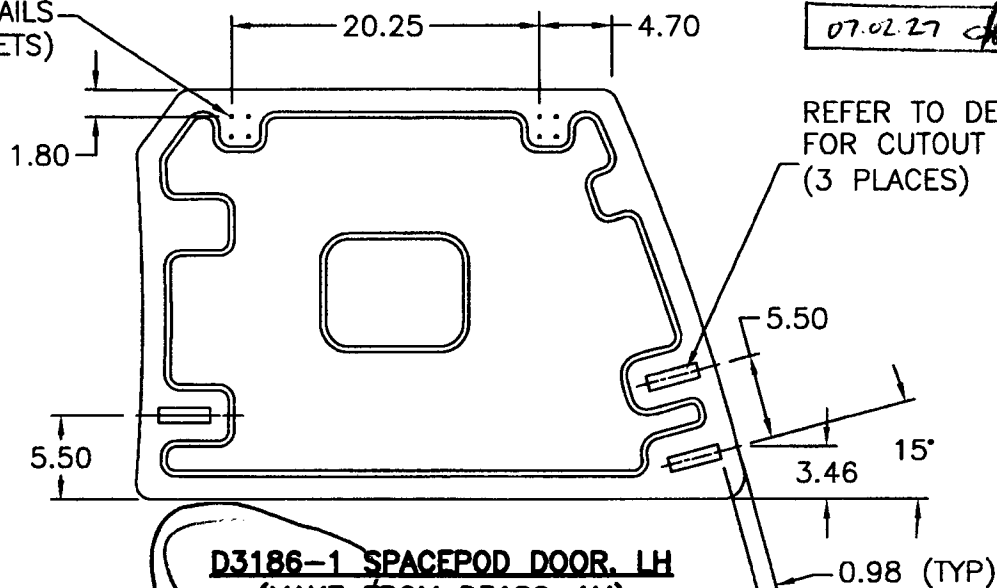
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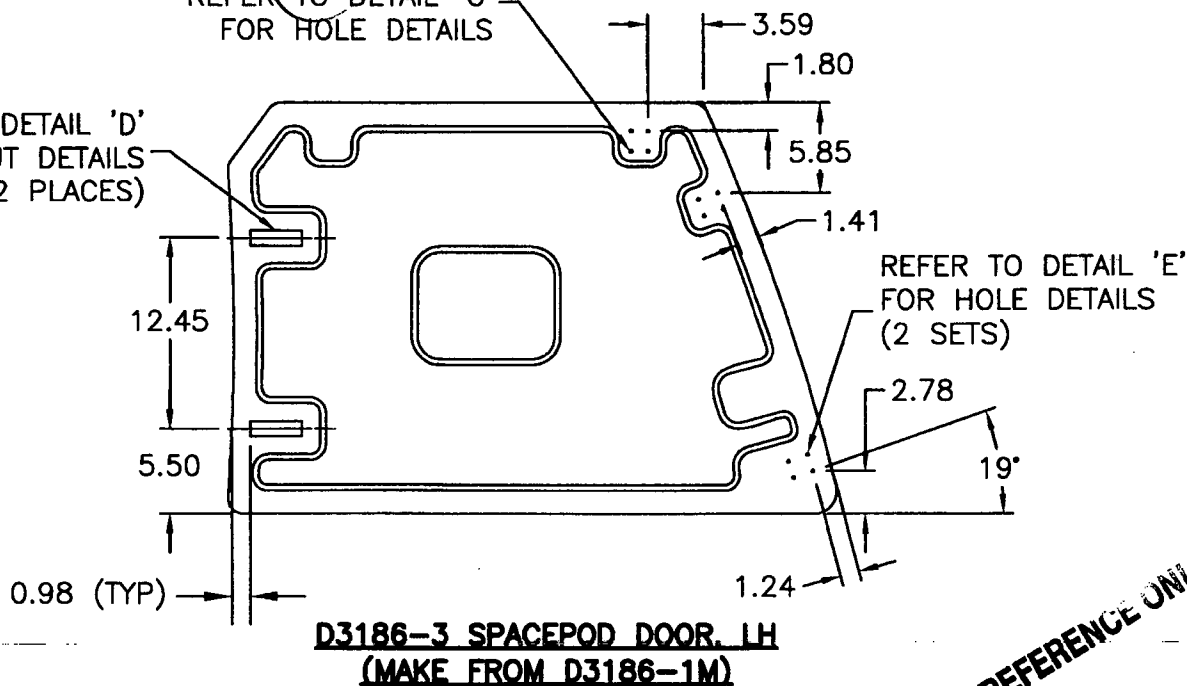
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CHECKED JB	APPROVED H	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)



REFER TO DETAIL 'C'
FOR HOLE DETAILS

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)



NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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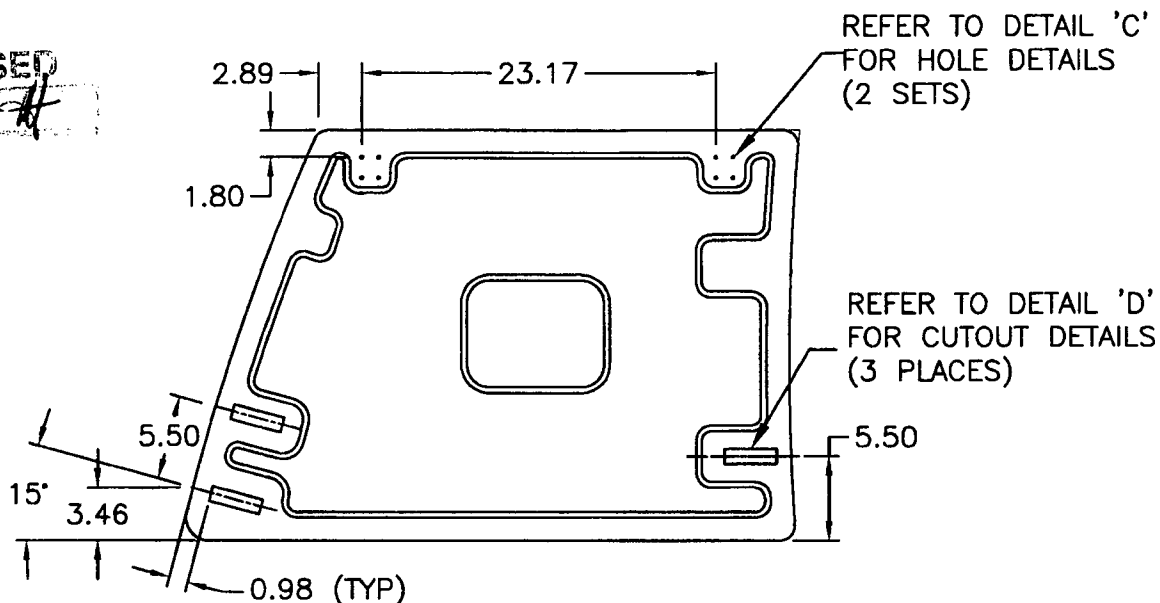
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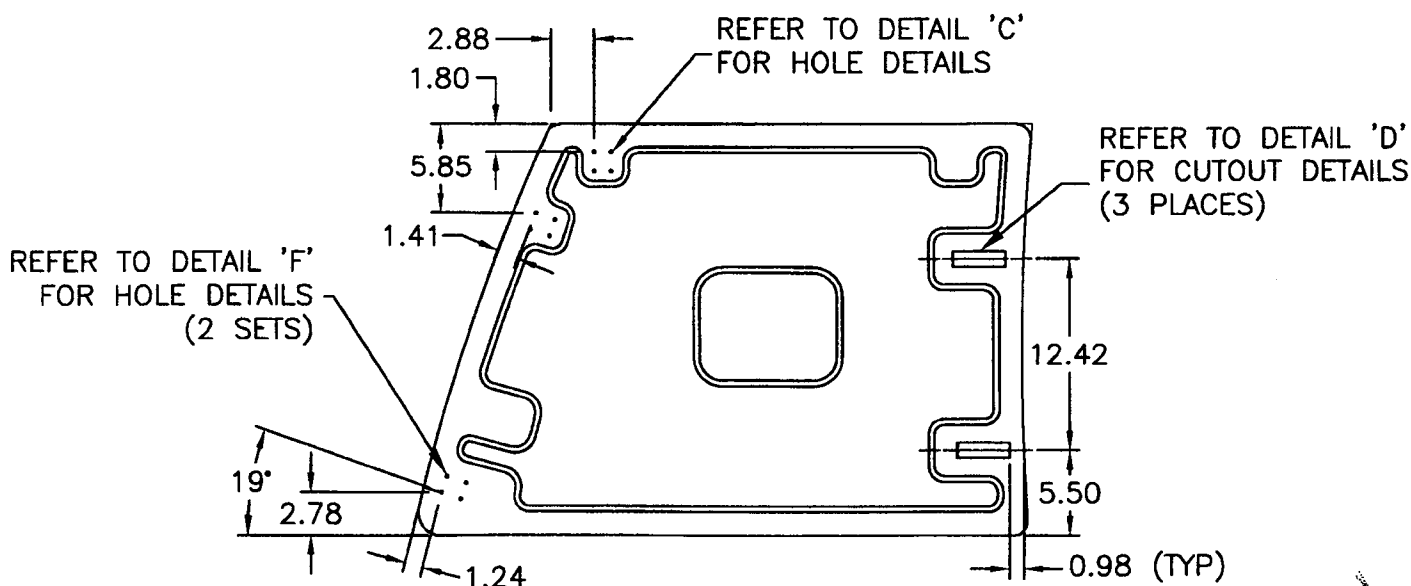
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CHECKED JB	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

RELEASED

07-02-27



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

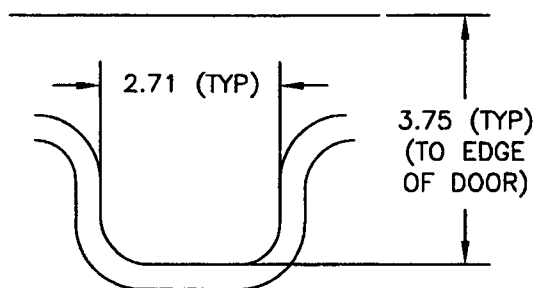
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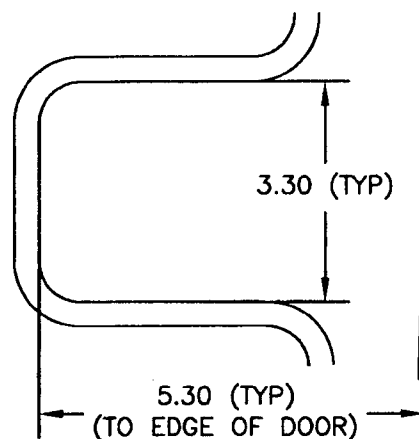
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CHECKED JB	APPROVED [Signature]	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22	TITLE SPACEPOD DOOR		SCALE NTS

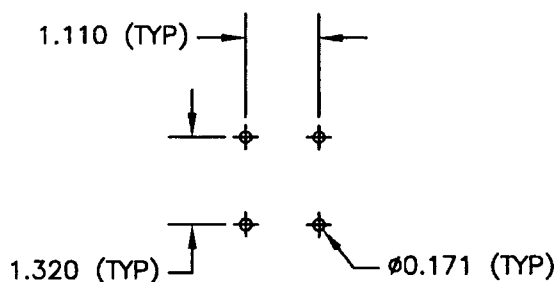


DETAIL A

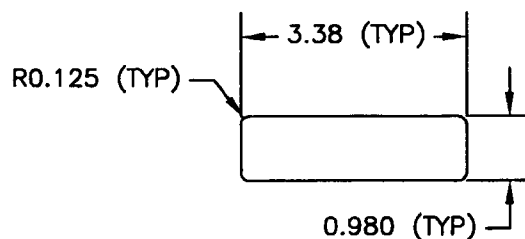


DETAIL B

RELEASED
07.02.27 [Signature]

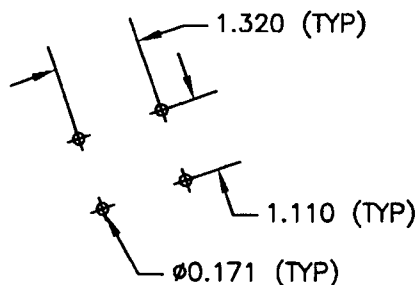


DETAIL C

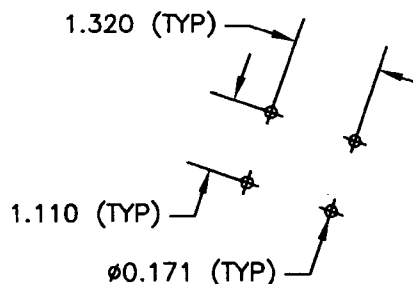


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Date: Thursday, 12/21/2006 12:54:37 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACEPOD DOOR LH
Job Number	: 30075		
Estimate Number	: 12598		
P.O. Number	: <i>N/A</i>	Part Number	: D31861M
This Issue	: 12/21/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D3186 REV <i>BC</i> <i>LE</i> 07.01.18
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 30074	Drawing Revision	: <i>BC</i> <i>LE</i> 07.01.18
	Type	Material	: <i>N/A</i>
	: PURCHASED PARTS	Due Date	: 2/15/2007
Written By	: <i>[Signature]</i>	Qty:	1
Checked & Approved By	: <i>[Signature]</i>	Um:	Each
Comment	: Est Rev:A New Issue 06-12-04 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: *2771*

Description: D3186-1M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

C 20612122 ①

2.0	D31861P	Spacepod Door
-----	---------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage. Ensure a copy of certification of conformity and process sheet from
 Delastek is attached.

7/8/1350

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins.

ml 07/08/15

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA**ml 07/08/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 5/10/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/21/2006 12:54:38 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 30075

Part Number: D31861M

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/21/09/17

Job Completion



U 12/21/09-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

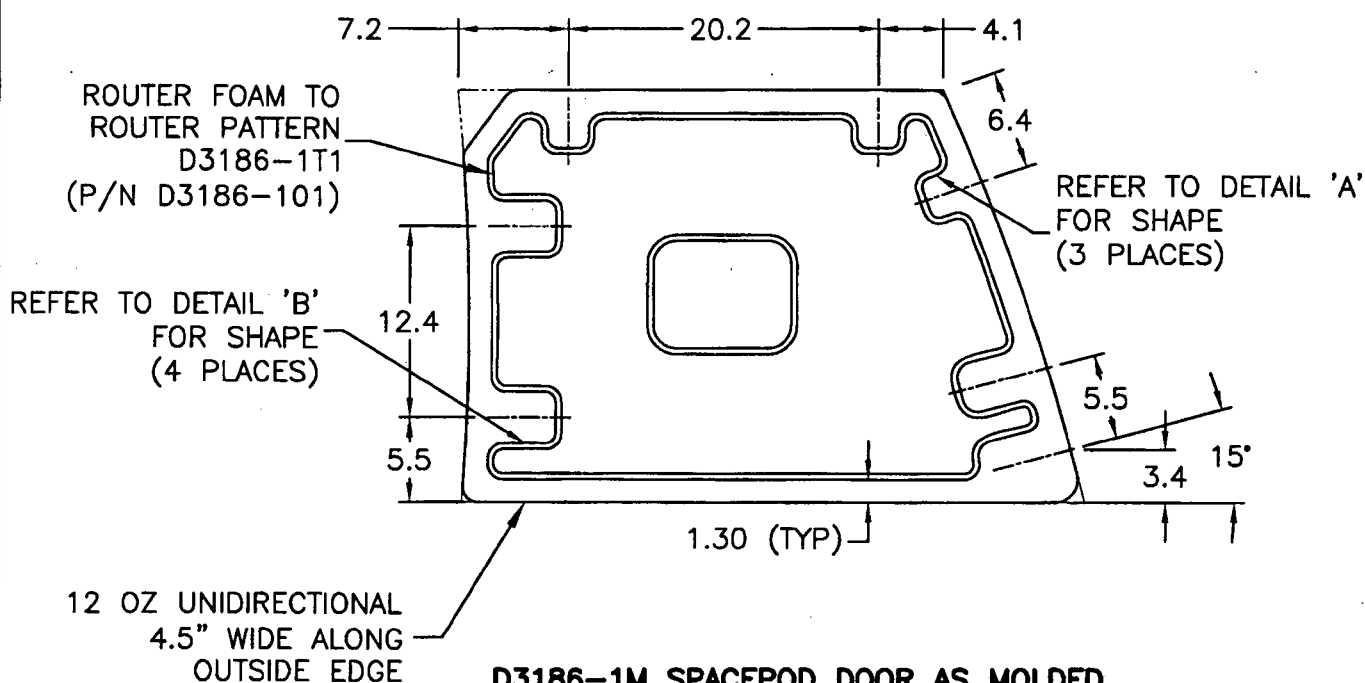
NOTE: Date & initial all entries



DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D3186	REV. C SHEET 1 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS
A	03.03.27	NEW ISSUE	
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	
C	06.12.13	REMOVED D0600-XXX LABELS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

RELEASED
06.12.22 H

NOTES:

- 1) USE MOLD DT8005 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 8) ALL DIMENSIONS ARE IN INCHES
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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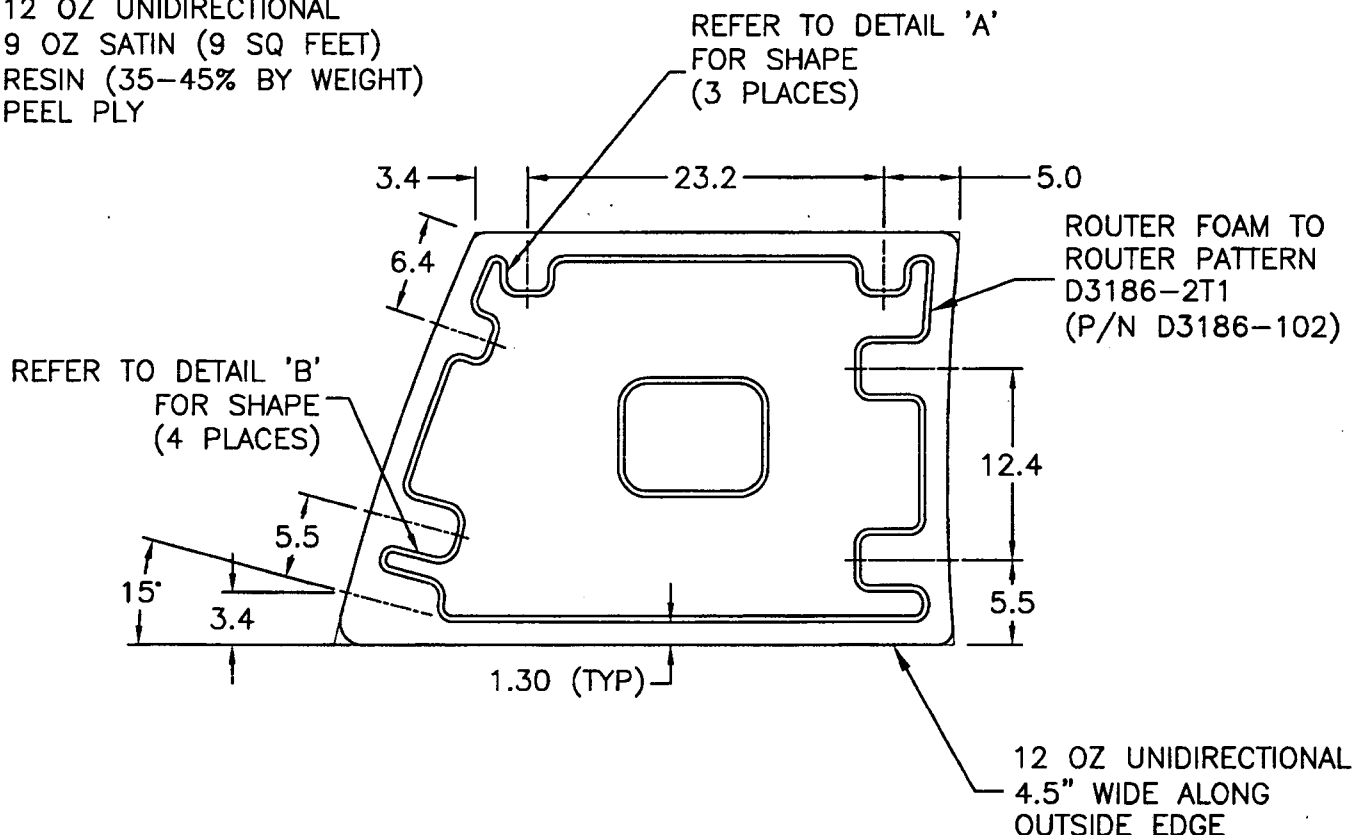


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CHECKED PH	APPROVED #	DRAWING NO. D3186	REV. C SHEET 2 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED
06.12.13



D3186-2M SPACEPOD DOOR AS MOLDED

NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
- 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
- 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
- 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 5) LAMINATE PER DART QSI 006 4.0
- 6) LAMINATION SCHEDULE PER THIS DRAWING -
- 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
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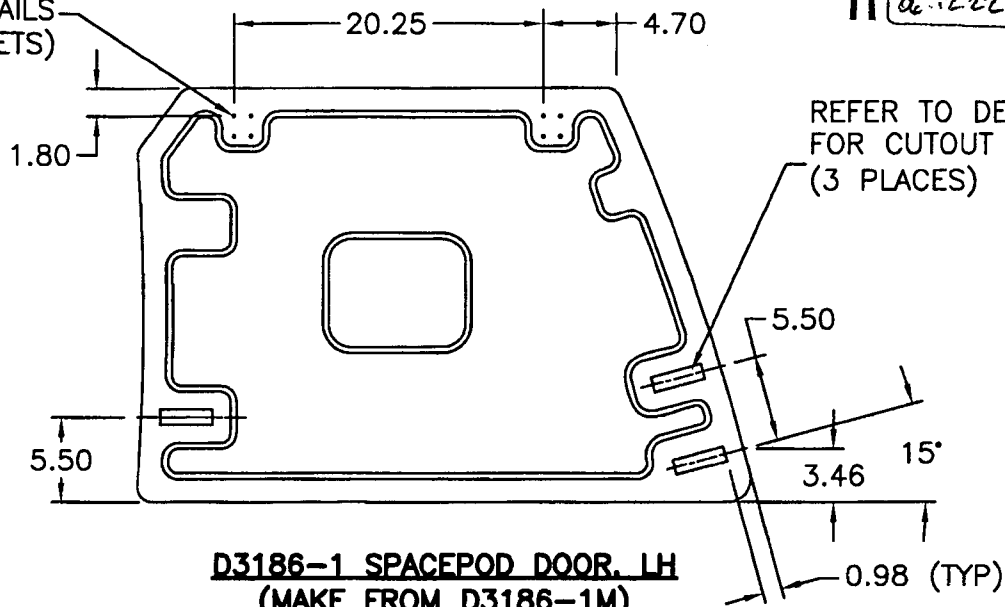
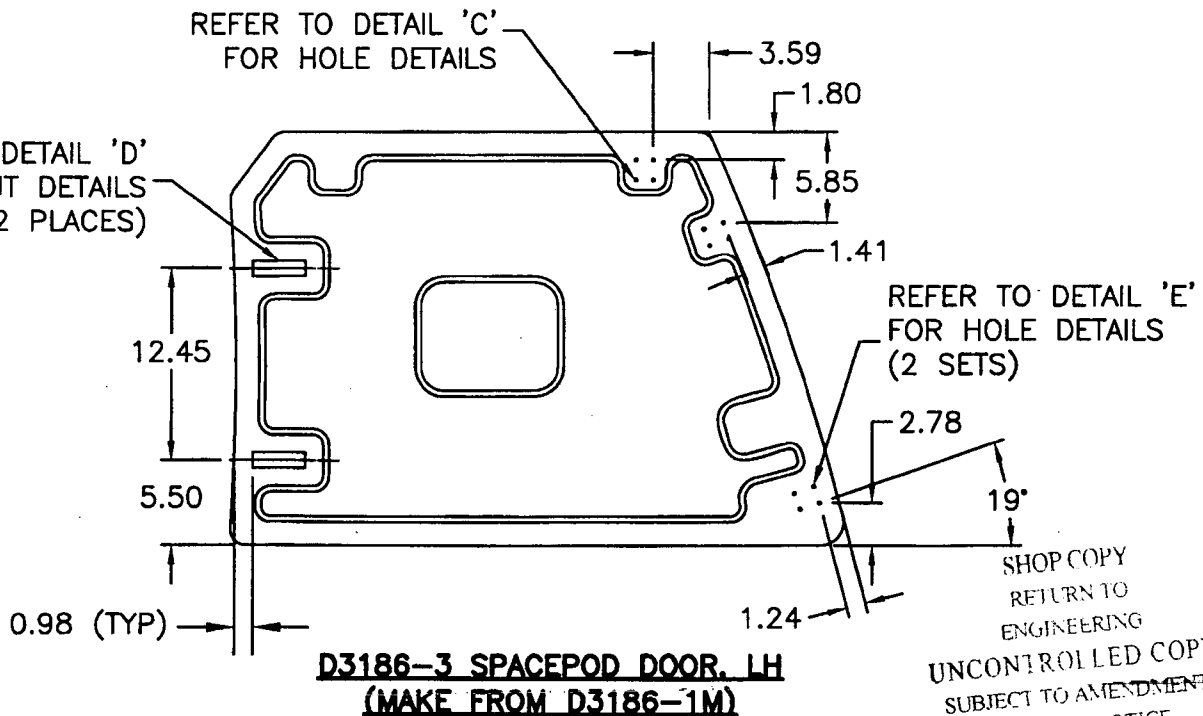
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DART

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3186	REV. C SHEET 3 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
*06-12-22*REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)REFER TO DETAIL 'C'
FOR HOLE DETAILSREFER TO DETAIL 'D'
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(2 PLACES)REFER TO DETAIL 'E'
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NO. *30075***NOTES:**

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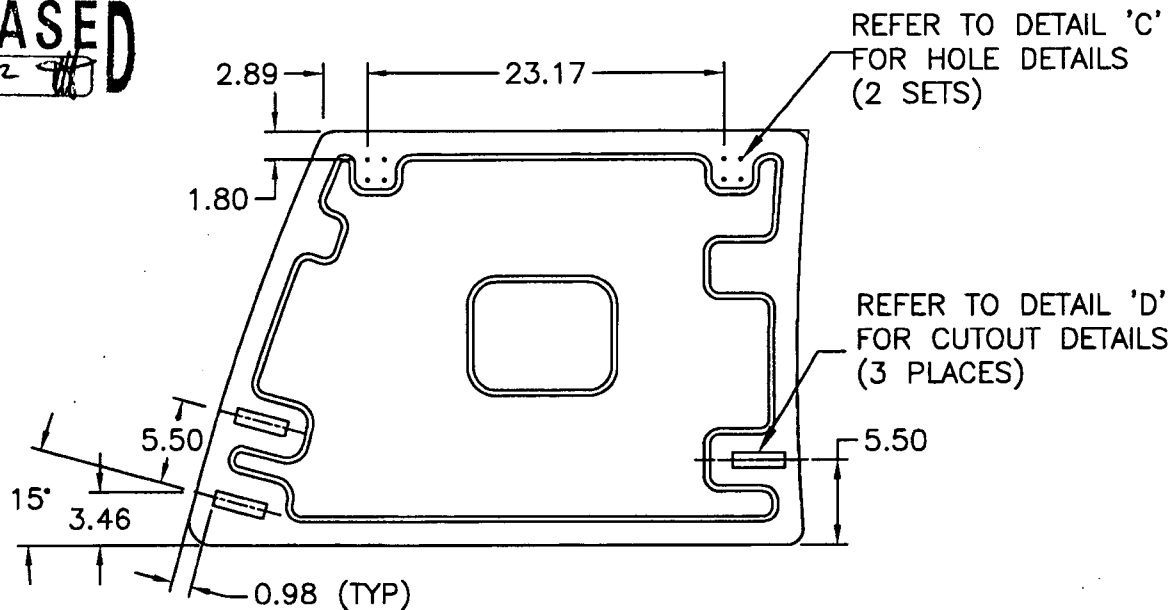
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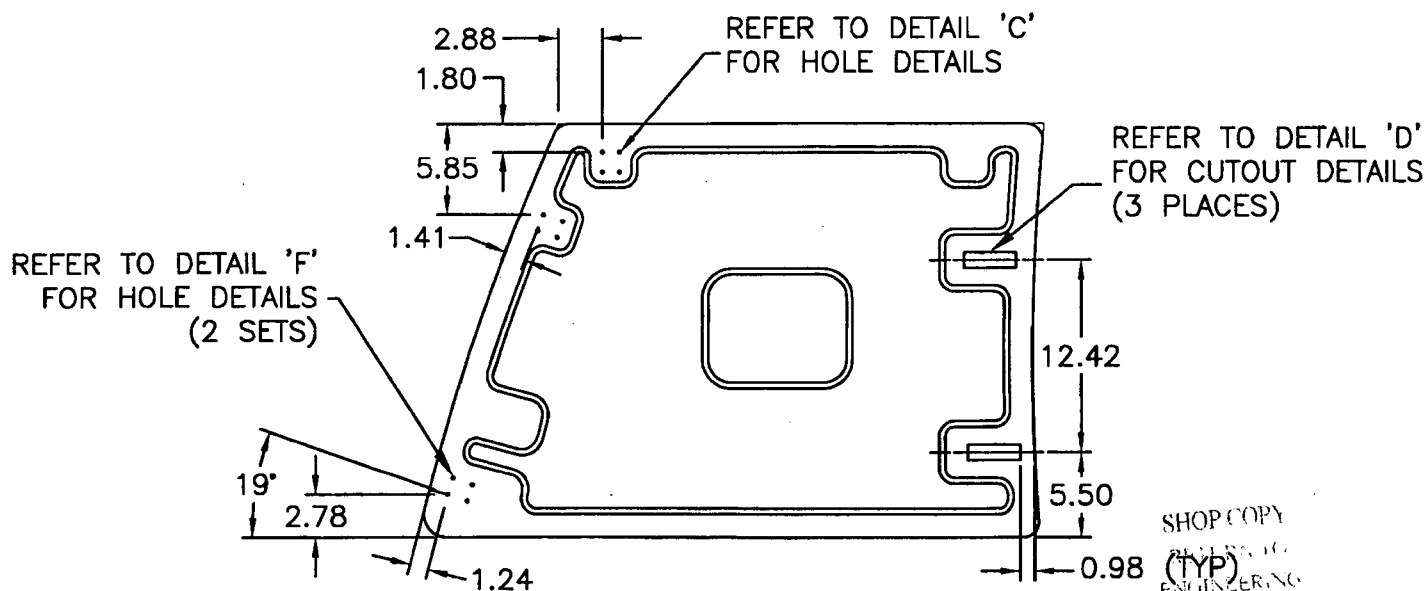


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CHECKED PH	APPROVED [Signature]	DRAWING NO. D3186	REV. C SHEET 4 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED
06.12.22



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

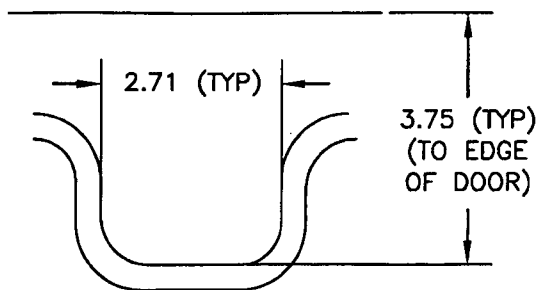
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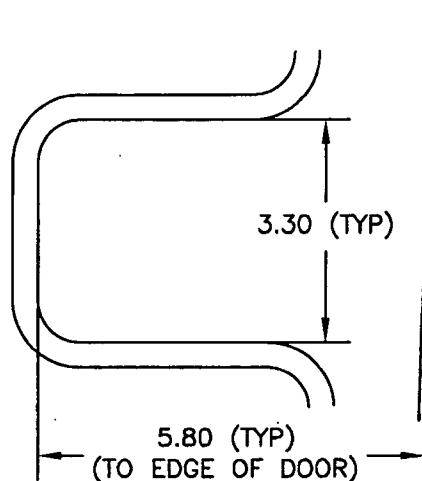
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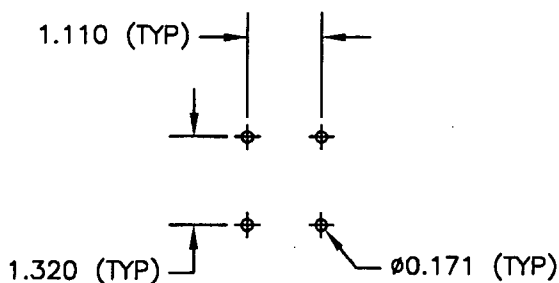
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DATE 06.12.13	TITLE SPACEPOD DOOR		SCALE NTS



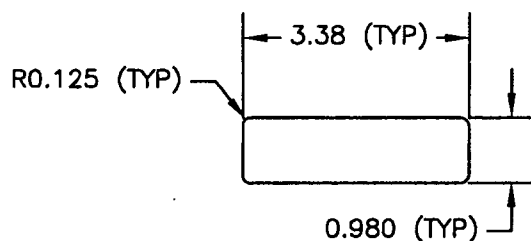
DETAIL A



DETAIL B

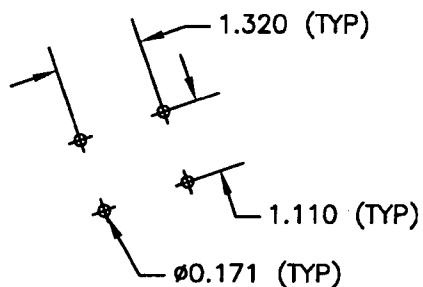


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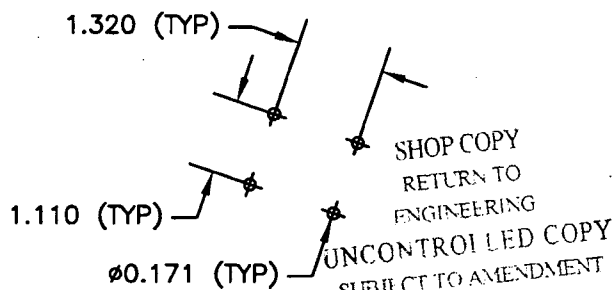


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:

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